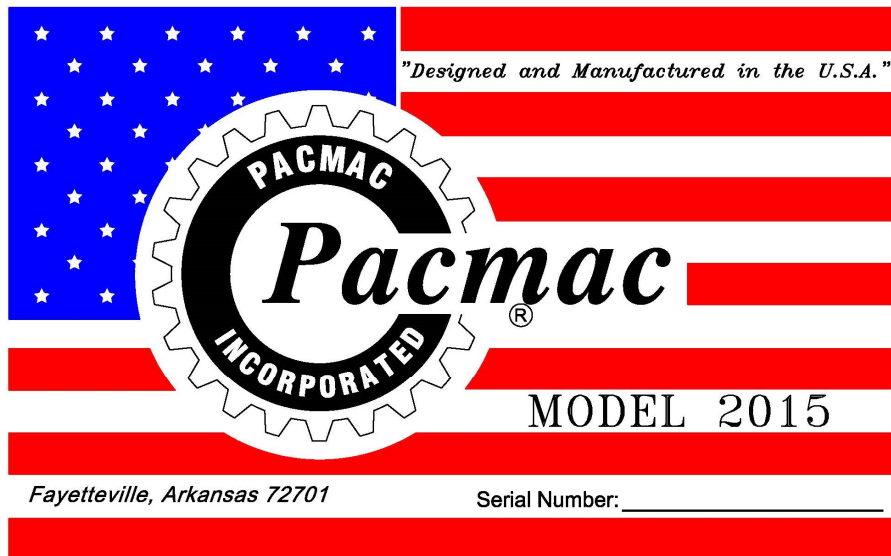


PARTS MANUAL

Serial # 2015B-0258



1501 S. Armstrong Avenue

Fayetteville, Arkansas 72701

(479) 521-0525

Pacmac Model 2015V2

Vertical Form, Fill & Seal Machine

Parts Manual

v210409

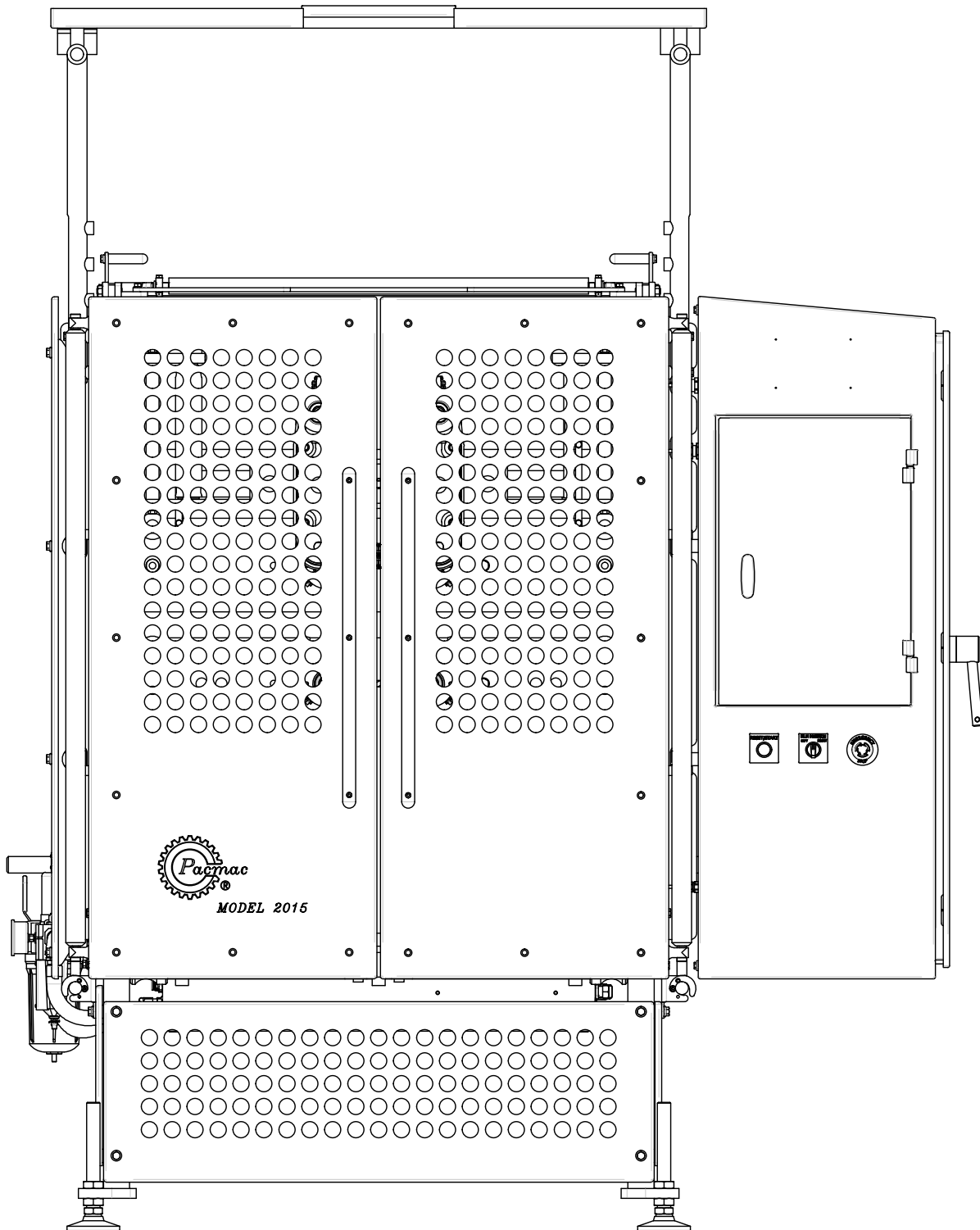


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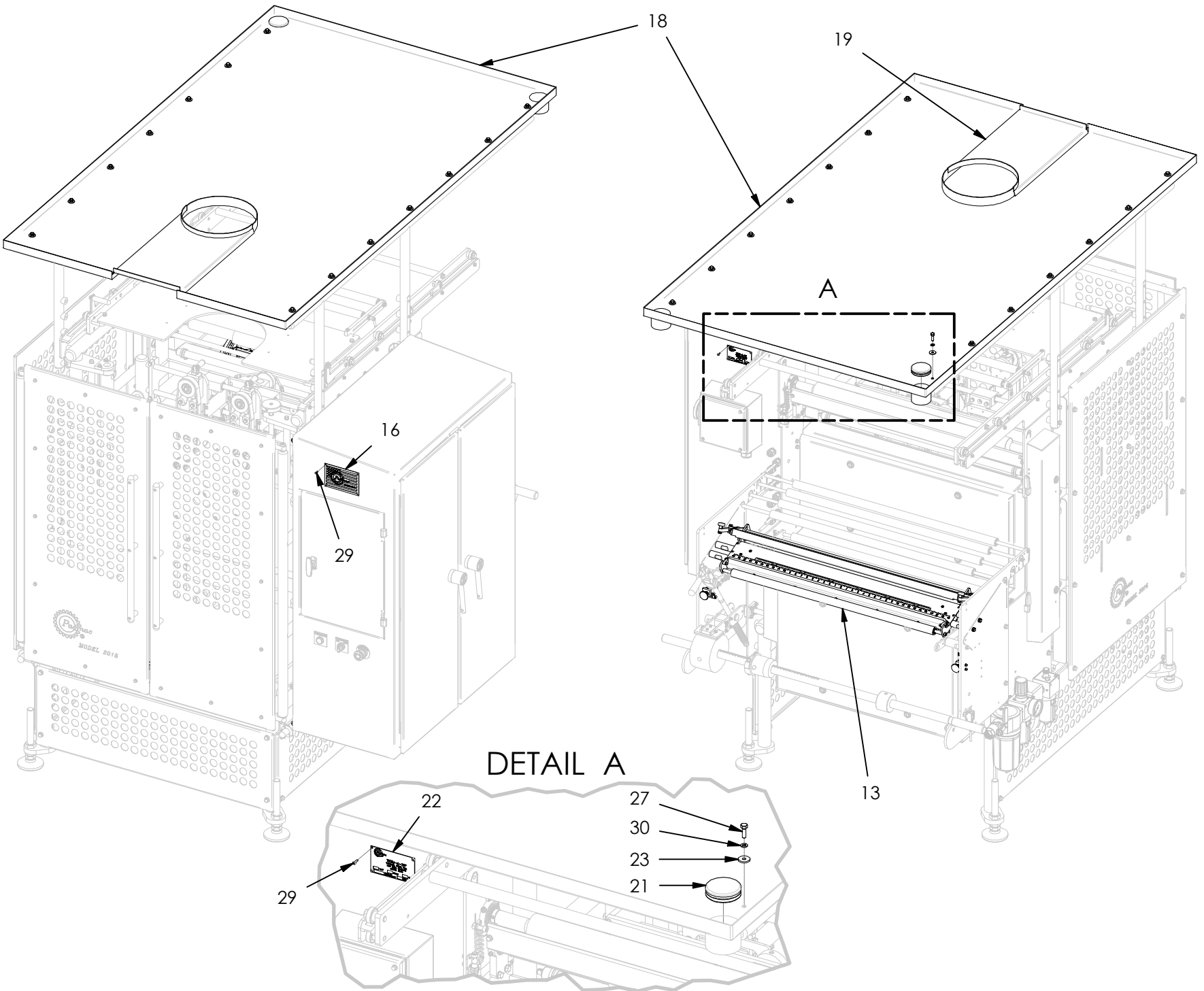
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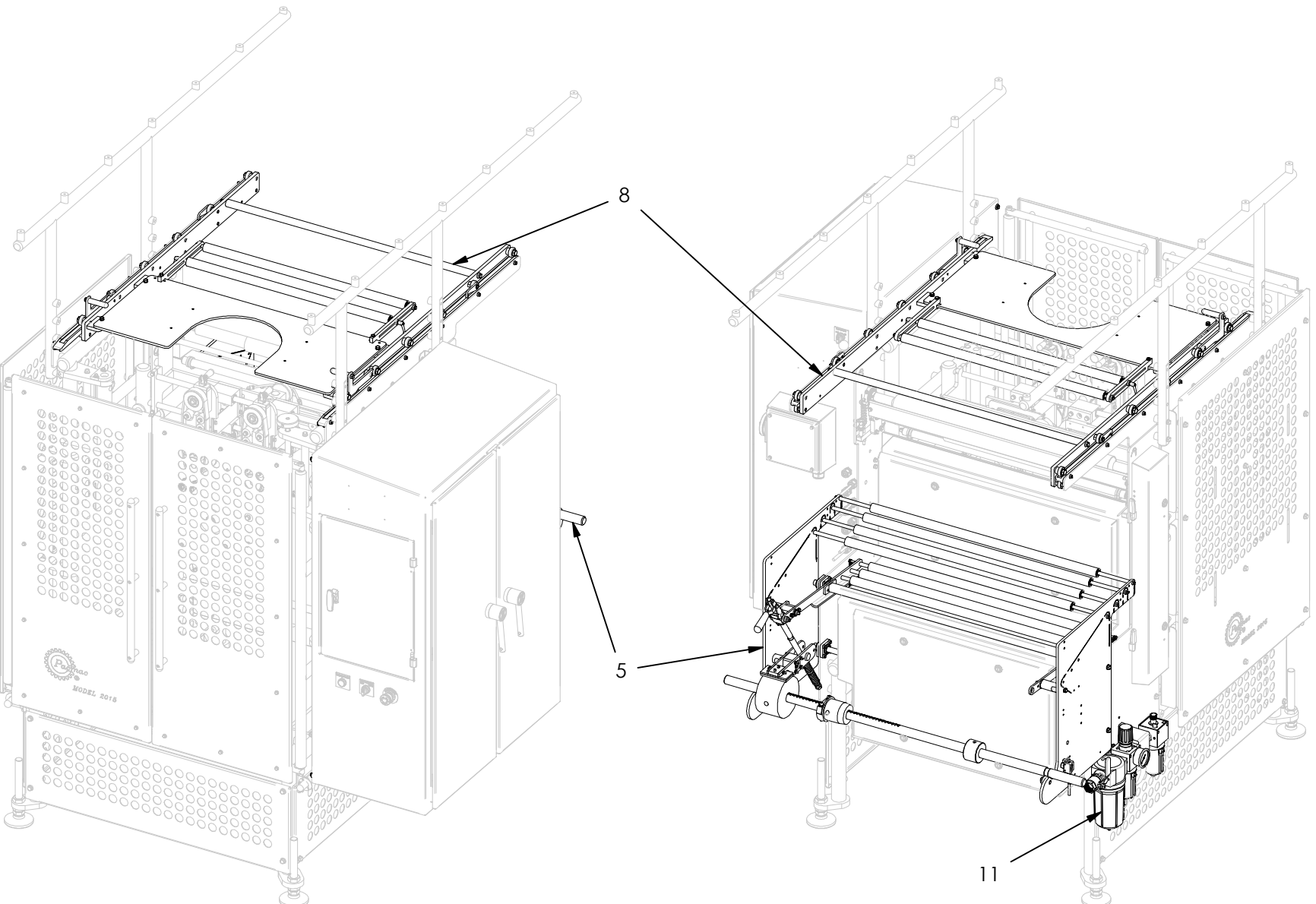
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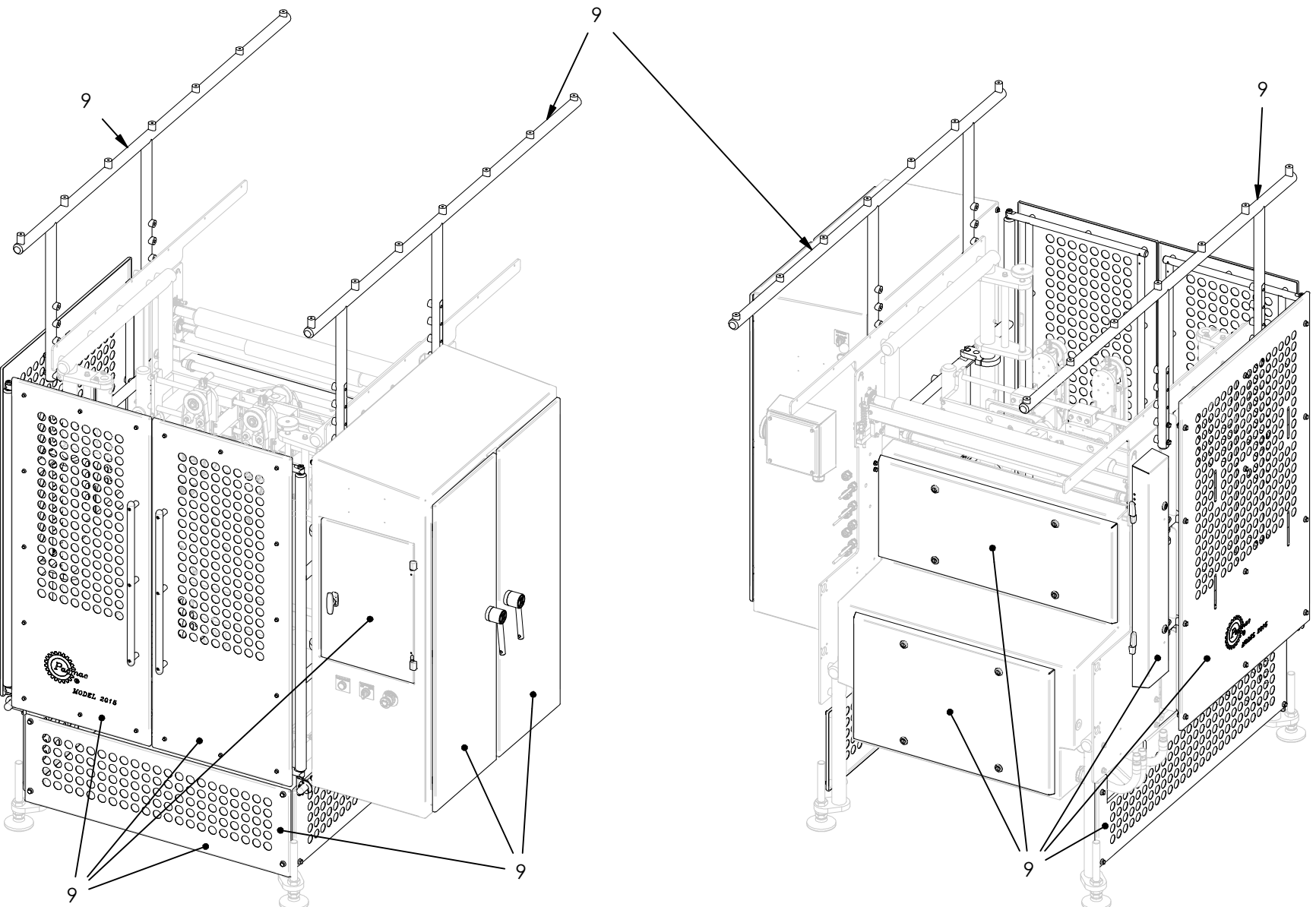
2015MCV2 Machine Core Assembly



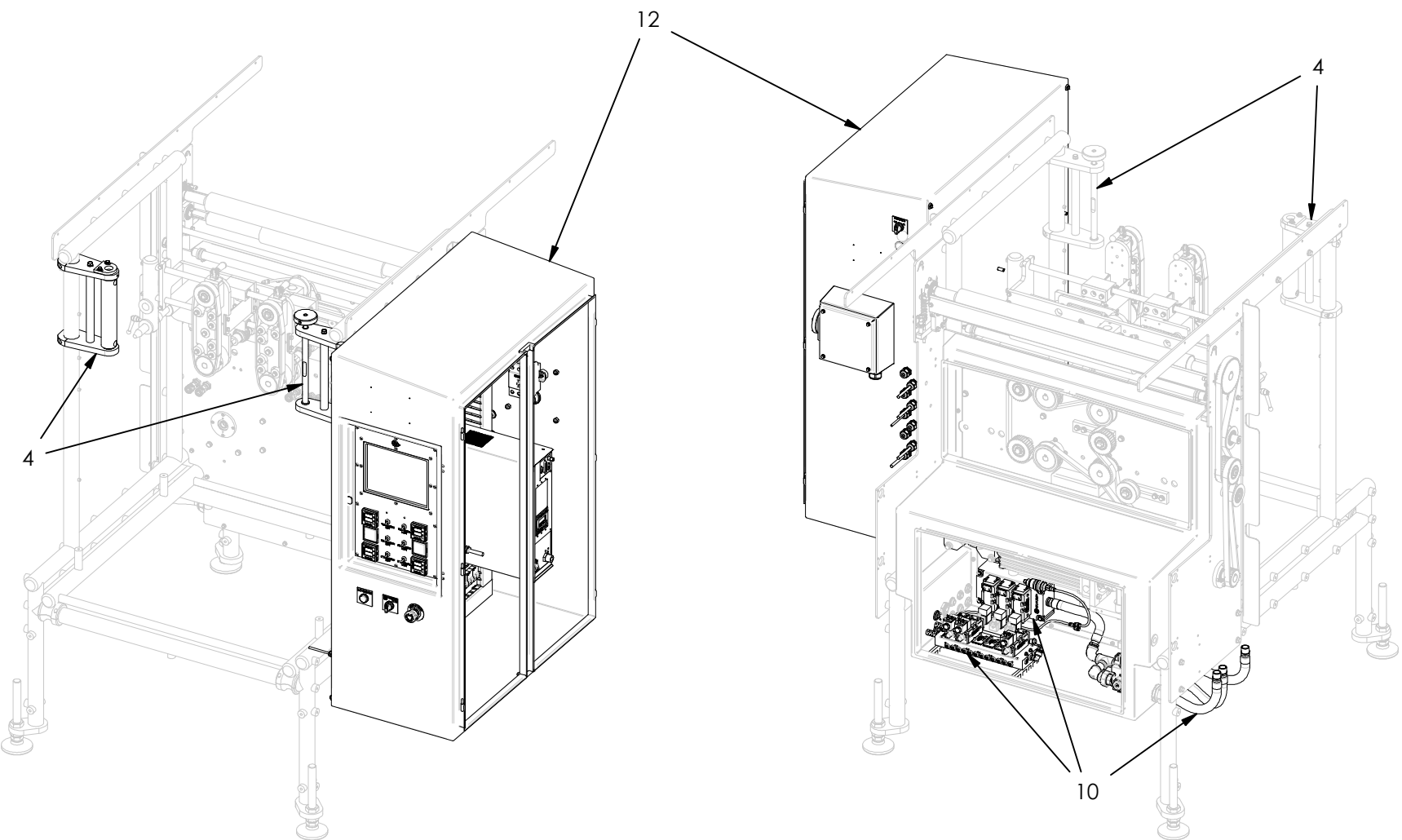
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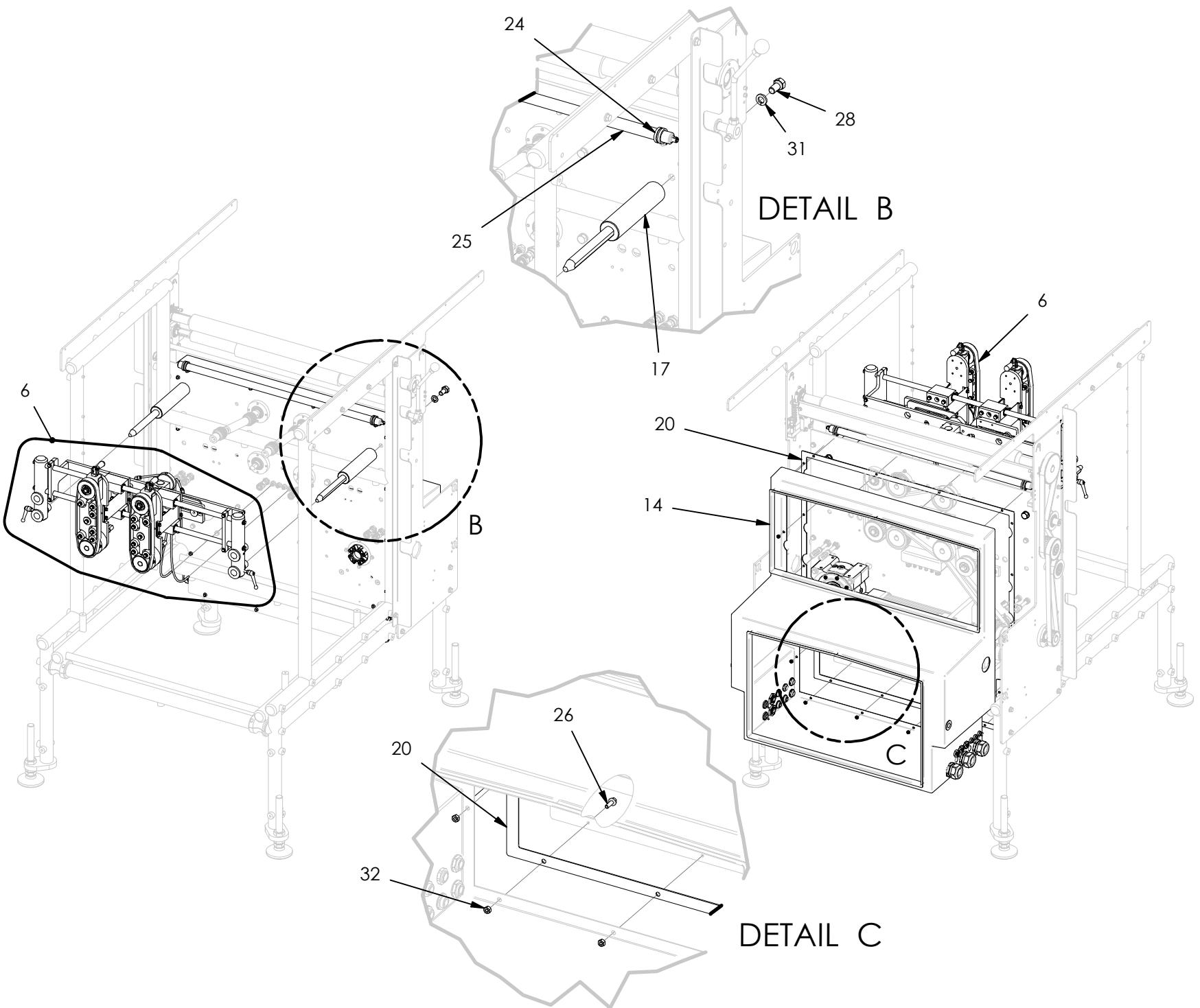
2015MCV2 Machine Core Assembly



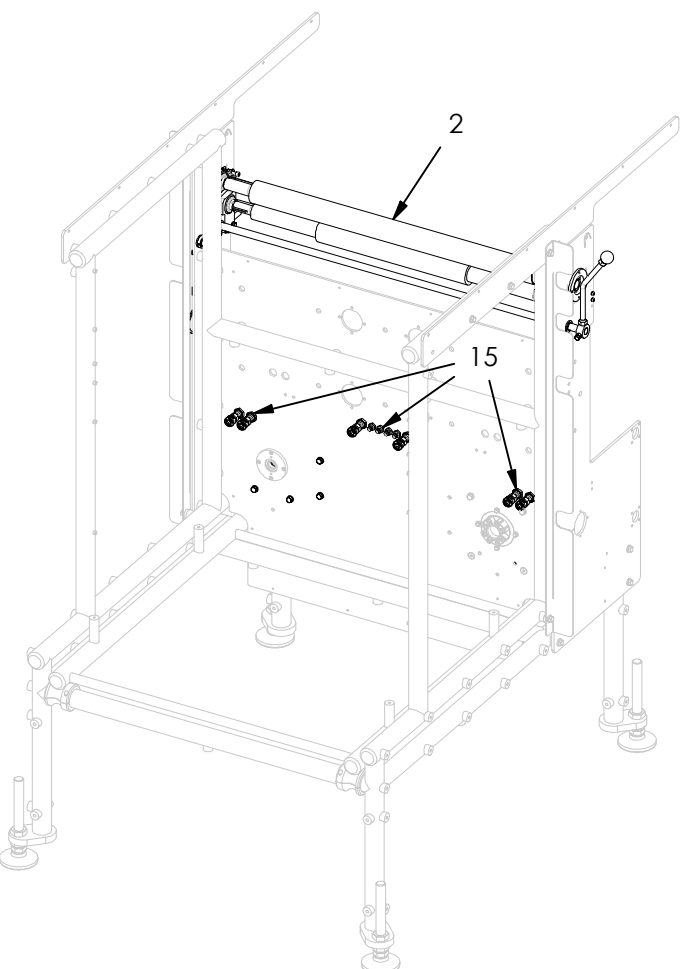
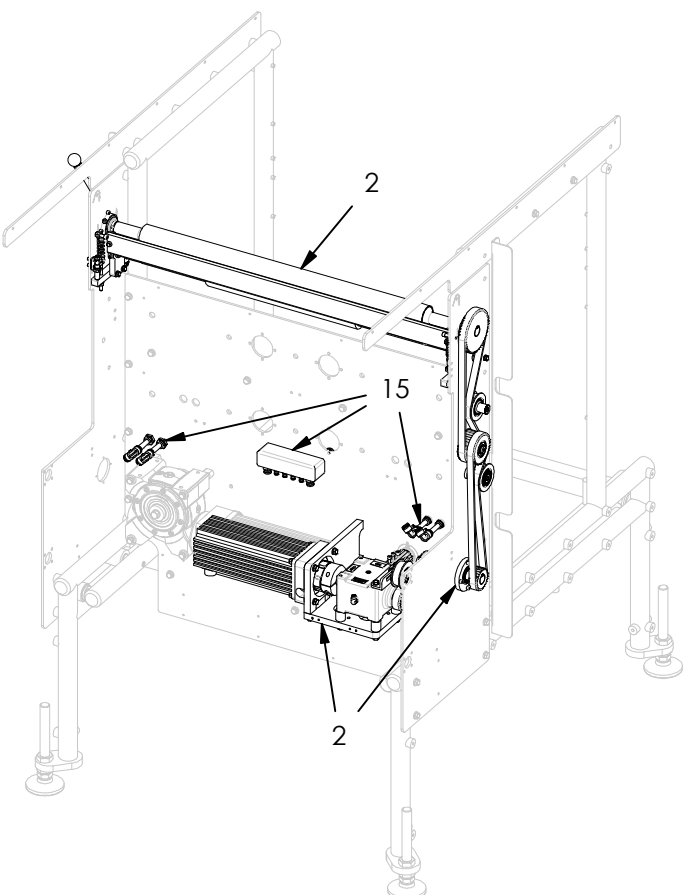
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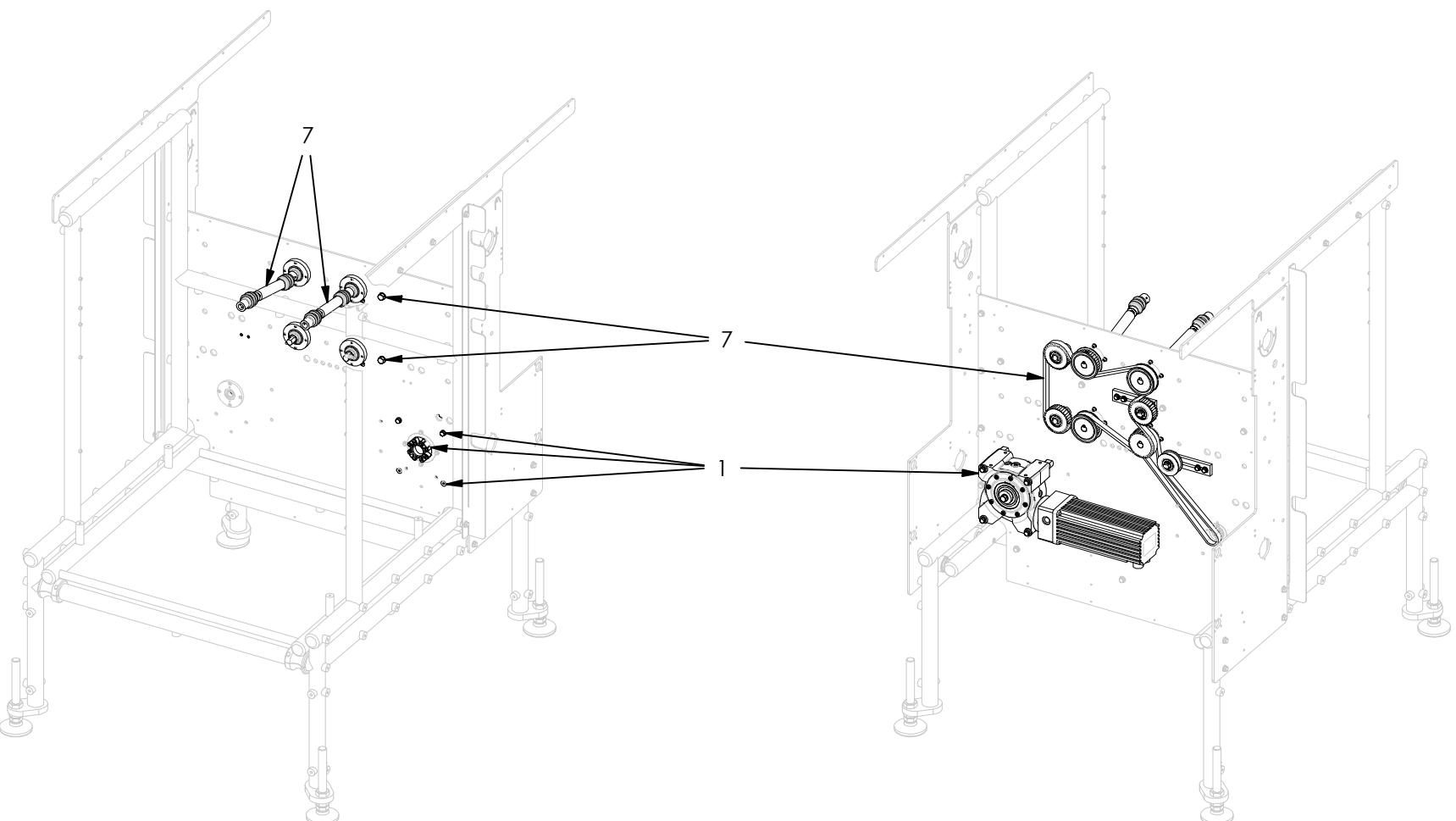
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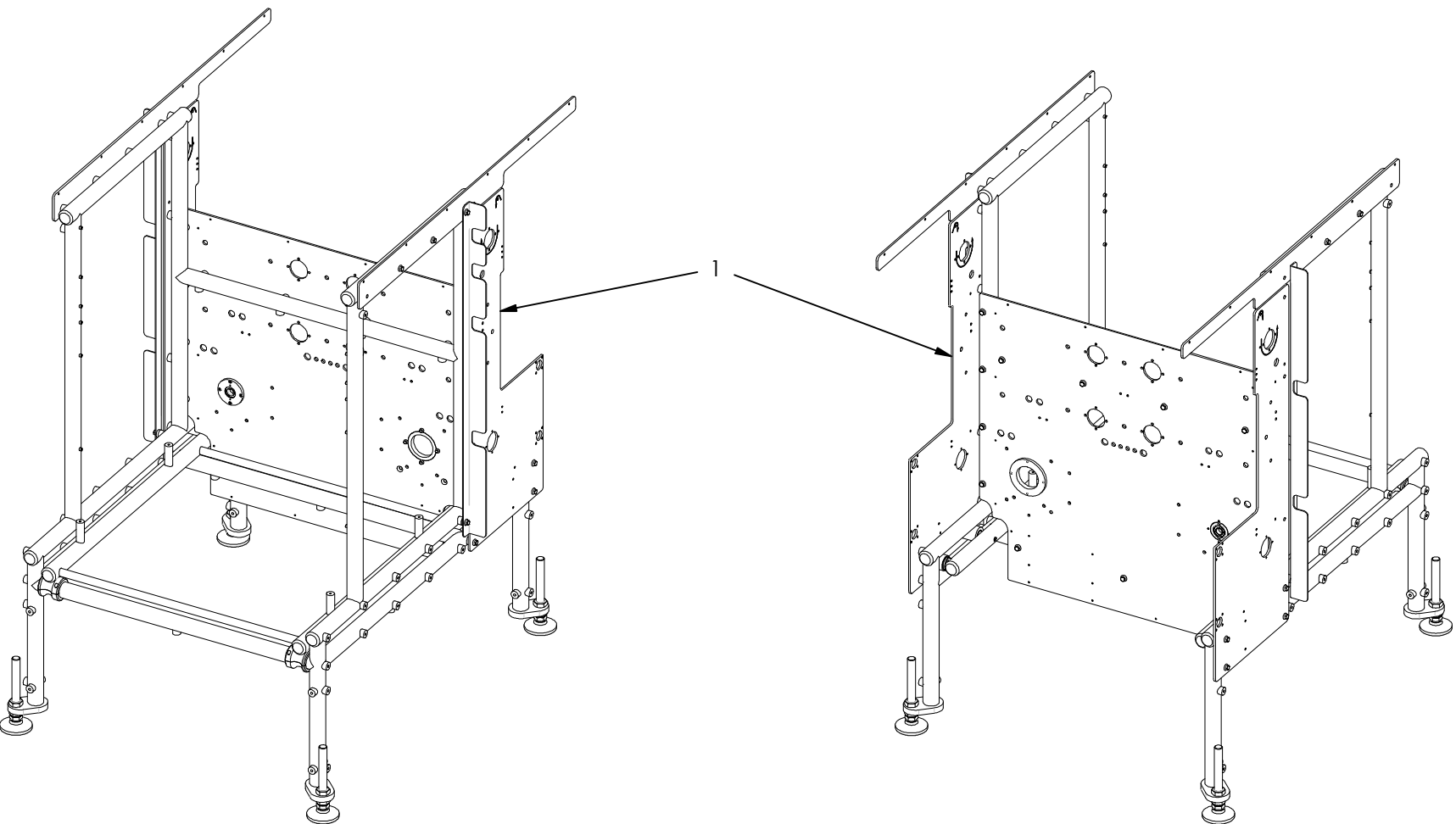
2015MCV2 Machine Core Assembly



2015MCV2 Machine Core Assembly

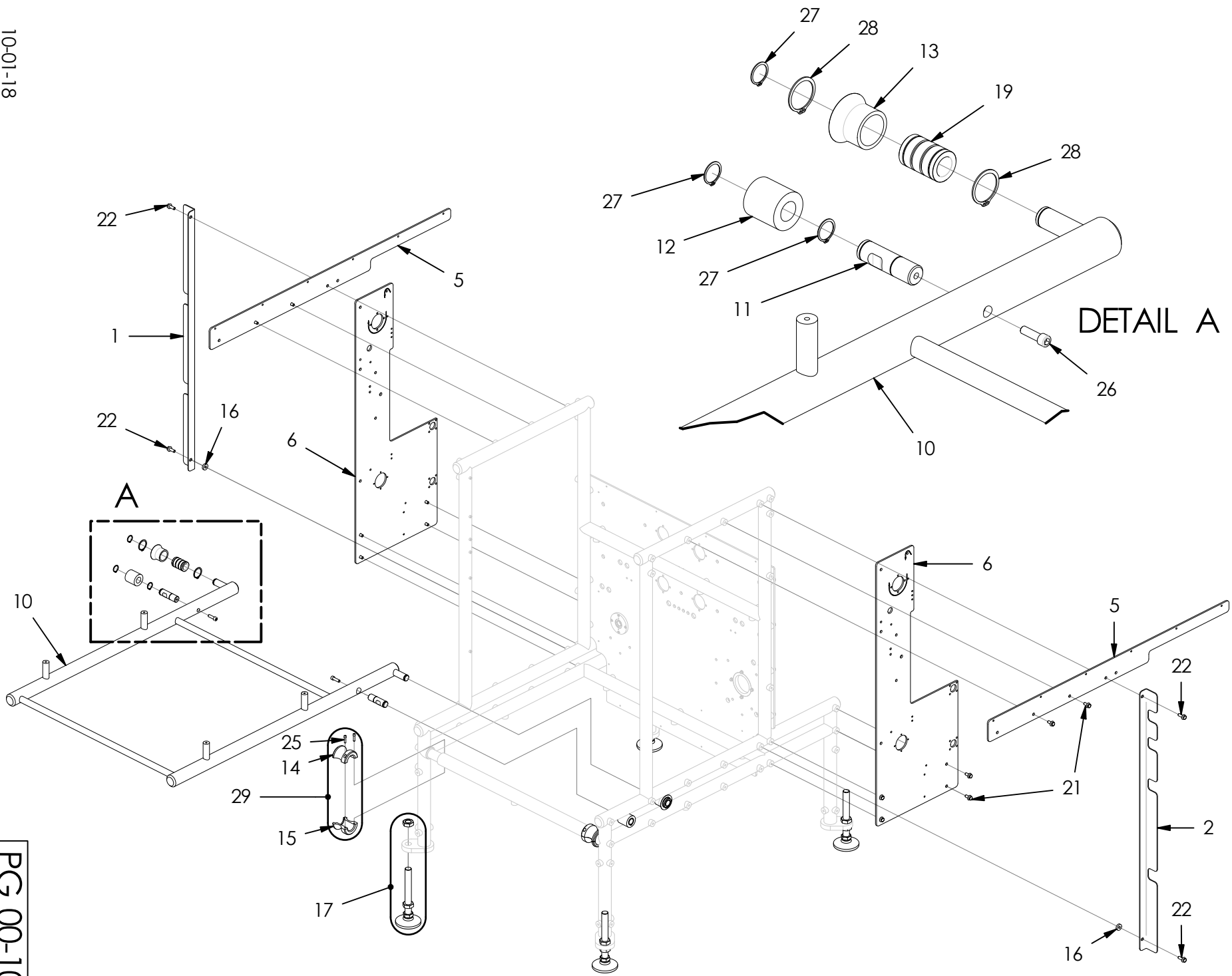


2015MCV2 Machine Core Assembly



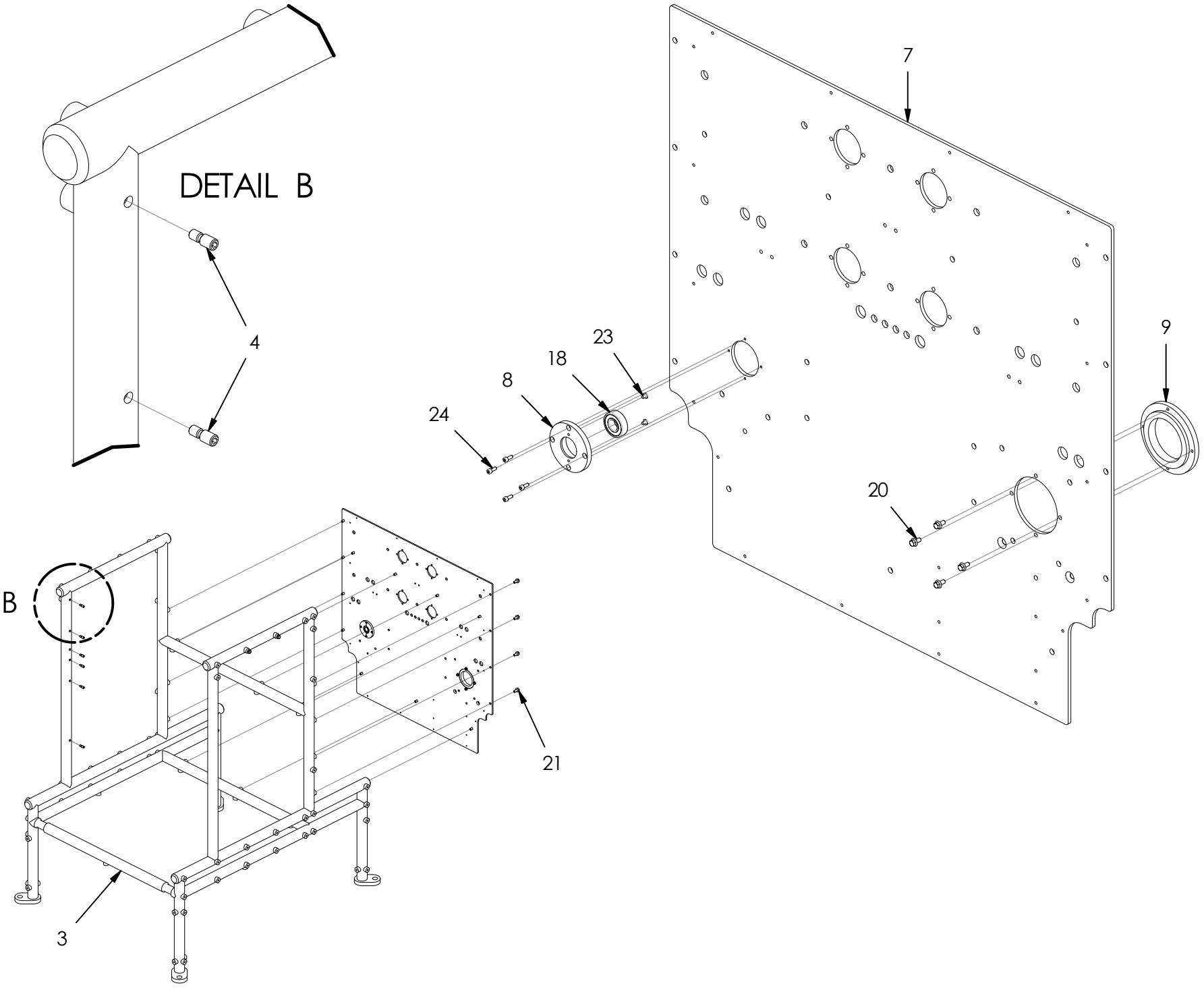
2015MCV2 Machine Core Assembly

ITEM	PART NUMBER	DESCRIPTION	QTY
1	1500	Frame Assembly	1
2	1501	Film Drive Assembly	1
3	1502RMPP	Power Pack Assembly	1
4	1503MK	Mounting Kit	1
5	1505	Film Unwind Assembly	1
6	1511S	Slide Assembly	1
7	1511T	Transmission Assembly	1
8	1512	Slide Assembly	1
9	1515	Covers Assembly	1
10	1516	Air Stack Assembly	1
11	1517	Air Control Assembly	1
12	1518	Electrical Cabinet Assembly	1
13	1521	Film Splice Assembly	1
14	A1515-0150	Rear Enclosure Sub Assembly	1
15	A1516-0039M	Manifold Assembly	1
16	1500-0000	Name Plate	1
17	1511-0007	Pull Belt Shaft	2
18	1515-0140	Drip Pan	1
19	1515-0140 -1	Drip Pan Insert	1
20	1515-0150G	Rear Enclosure Gasket	1
21	1515-0156	Plug	1
22	1518-0050	Spec Plate	1
23	9500-62	Washer	14
24	9516-0090	Loom Clamp	2
25	9518-0086	3' Work Light	1
26	1/4-20X3/4FB	Flange Bolt	18
27	5/16-18X1HH	Hex Head Bolt	14
28	5/8-11X1 1/4HH	Hex Head Bolt	2
29	6-32X1/2PPH	Phillips Pan Head Screw	8
30	5/16LW	Lock Washer	14
31	5/8LW	Lock Washer	2
32	1/4-20HN	Hex Nut	18



1500 Frame Assembly

1500 Frame Assembly



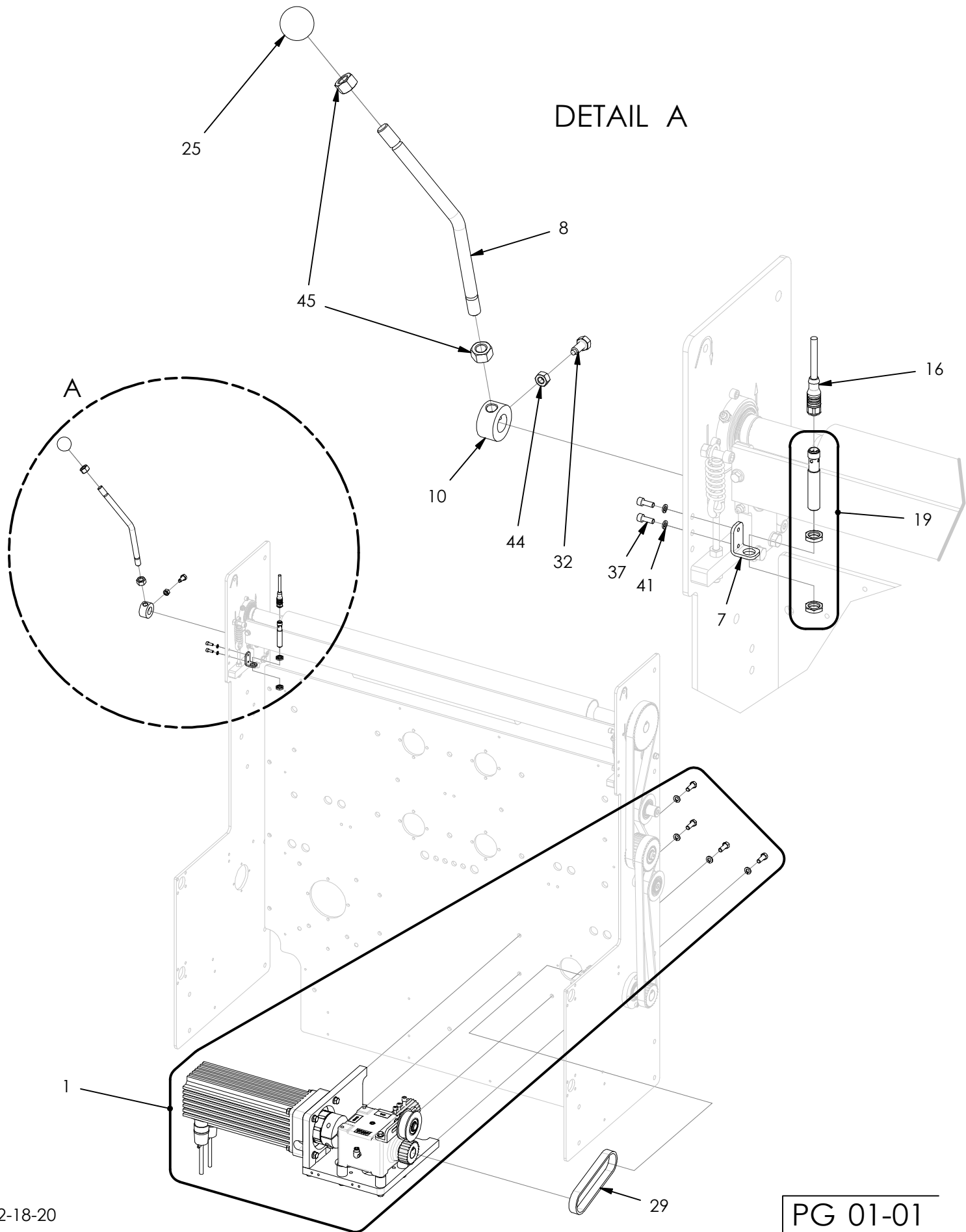
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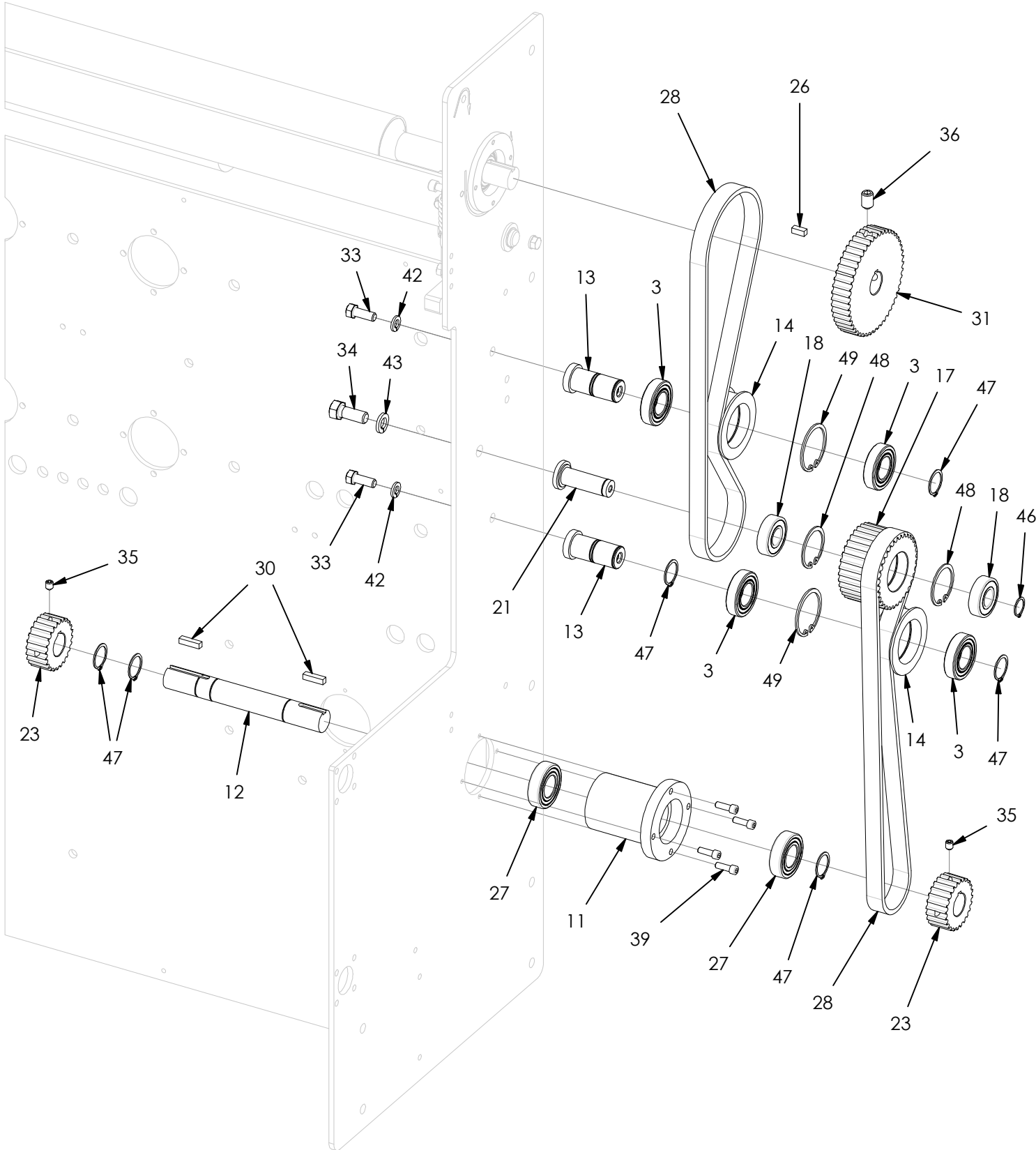
1500 Frame Assembly

ITEM	PART NUMBER	DESCRIPTION	QTY
1	1500-13	Cover Strip, LH	1
2	1500-14	Cover Strip, RH	1
3	1500-6	Rod Frame Assembly	1
4	1500-6 -23	Locator Pin	12
5	1500-7 -2	Side Frame	2
6	1500-7V2	Side Frame	2
7	1500-8	Bulkhead	1
8	1500-96 -1BH	Bearing Housing	1
9	1500-96RM	Cover Plate	1
10	1512-0012	Jaw Slide	1
11	1512-0012 -4	Axle	2
12	1512-0012 -7	Roller	2
13	1512-0012 -8	Roller	2
14	1512-0012 -9A	Roller	2
15	1512-0012 -9B	Roller	2
16	1515-0147	Spacer	2
17	9200-0025	Foot Assembly	4
18	9200-0038	Bearing	1
19	9210-0014	Bushing	2
20	1/4-20X1/2FB	Flange Bolt	4
21	3/8-16X3/4FB	Flange Bolt	27
22	3/8-16X1FB	Flange Bolt	4
23	10-32X1/4PPH	Phillips Pan Head Screw	2
24	10-32X1/2SH	Socket Head Bolt	4
25	1/4-20X1SH	Socket Head Bolt	4
26	3/8-16X1 1/4SH	Socket Head Bolt	2
27	1EXT	Snap Ring	6
28	1 9/16EXT	Snap Ring	4
29	1512-0012 -9	Roller Set	0

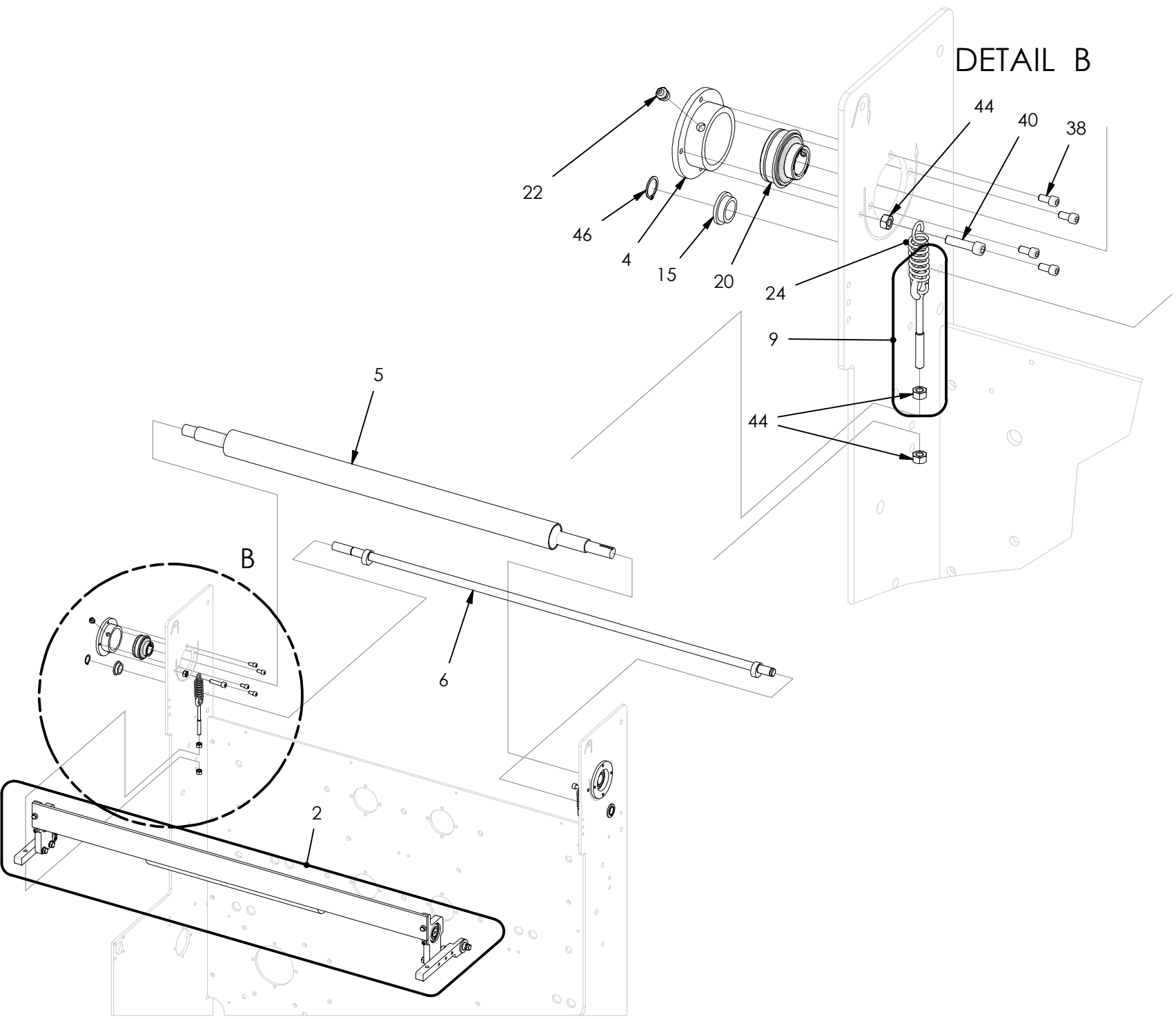
1501 Film Drive Assembly



1501 Film Drive Assembly



1501 Film Drive Assembly



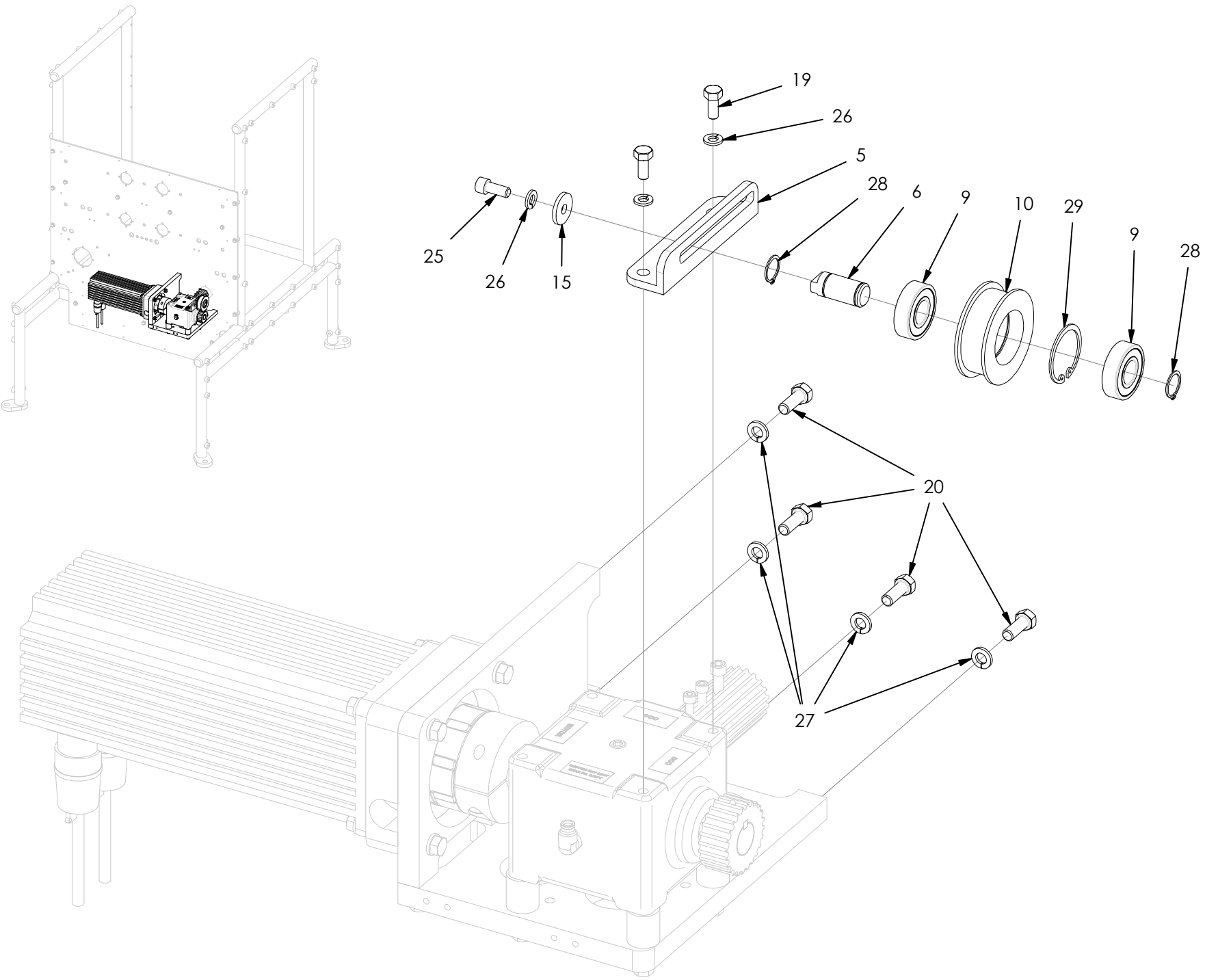
1501 Film Drive Assembly

ITEM	PART NUMBER	DESCRIPTION	QTY
1	1501-A001	Gear Box Sub-Assembly	1
2	1501-A002	Nip Roller Sub-Assembly	1
3	1500-0038	Bearing	4
4	1500-35	Bearing Housing	2
5	1501-0006	Drive Roller	1
6	1501-0013	Cam Shaft Assembly	1
7	1501-0018	Sensor Bracket	1
8	1501-0019V2	Handle	1
9	1501-0023	Eye Bolt	2
10	1501-0024	Collar	1
11	1501-0109	Bearing Housing	1
12	1501-0110	Shaft	1
13	1501-0111	Tension Stud Assembly	2
14	1501-0112	Tension Idler	2
15	1501-0113	Bushing	2
16	1518-A223	Nip Roller Sensor Cable	0
17	9200-0036	Dual Cog	1
18	9200-0038	Bearing	2
19	9200-0042	Sensor	1
20	9200-0047SS	St Stl Bearing	2
21	9200-0056	Stud	1
22	9200-0069	Grease Zerk	2
23	9201-0008	Drive Cog	2
24	9201-0030	St Stl Spring	2
25	9201-0036	Knob	1
26	9201-0041	Key (1/4" X 5/8")	1
27	9201-0067	Bearing	2
28	9202-0042	Timing Belt	2
29	9211-0059 -20	Timing Belt	1
30	9211-0062	Key (1/4" X 1")	2
31	9501-0010	Driven Cog	1
32	5/16-18X3/4HHDP	Dog Point Hex Head Bolt	1
33	3/8-16X1HH	Hex Head Bolt	2
34	1/2-13X1 1/4HH	Hex Head Bolt	1
35	5/16-18X3/8SS	Set Screw	2
36	1/2-13X3/4SS	Set Screw	1
37	10-32X1/2SH	Socket Head Bolt	2
38	1/4-20X1/2SH	Socket Head Bolt	8
39	1/4-20X3/4SH	Socket Head Bolt	4
40	5/16-18X1 1/4SH	Socket Head Bolt	2

1501 Film Drive Assembly

ITEM	PART NUMBER	DESCRIPTION	QTY
41	#10LW	Lock Washer	2
42	3/8LW	Lock Washer	2
43	1/2LW	Lock Washer	1
44	5/16-18HN	Hex Nut	7
45	1/2-13HN	Hex Nut	2
46	3/4EXT	Snap Ring	3
47	1EXT	Snap Ring	6
48	1 3/4INT	Snap Ring	2
49	2INT	Snap Ring	2

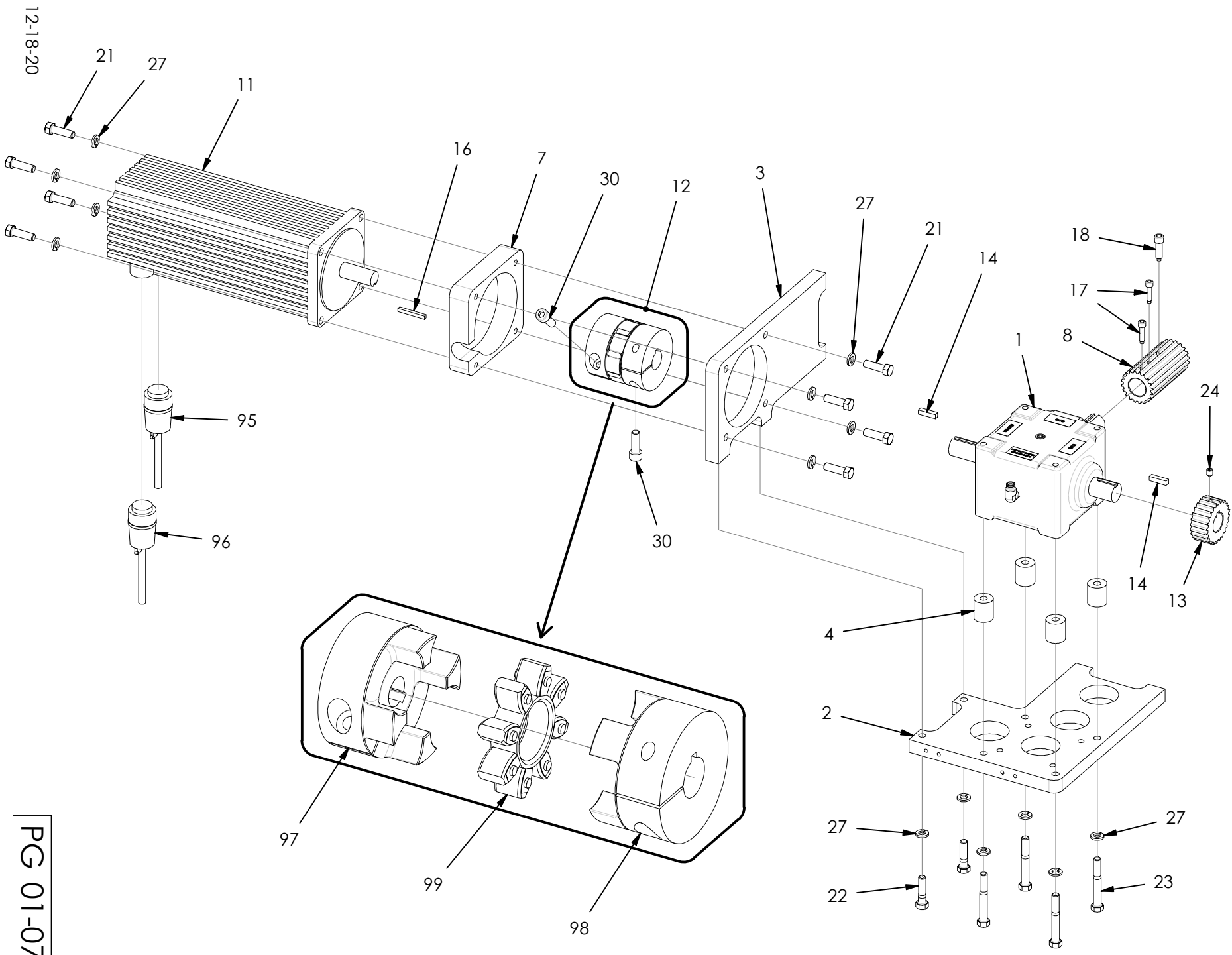
1501-A001 Gear Box Sub-Assembly



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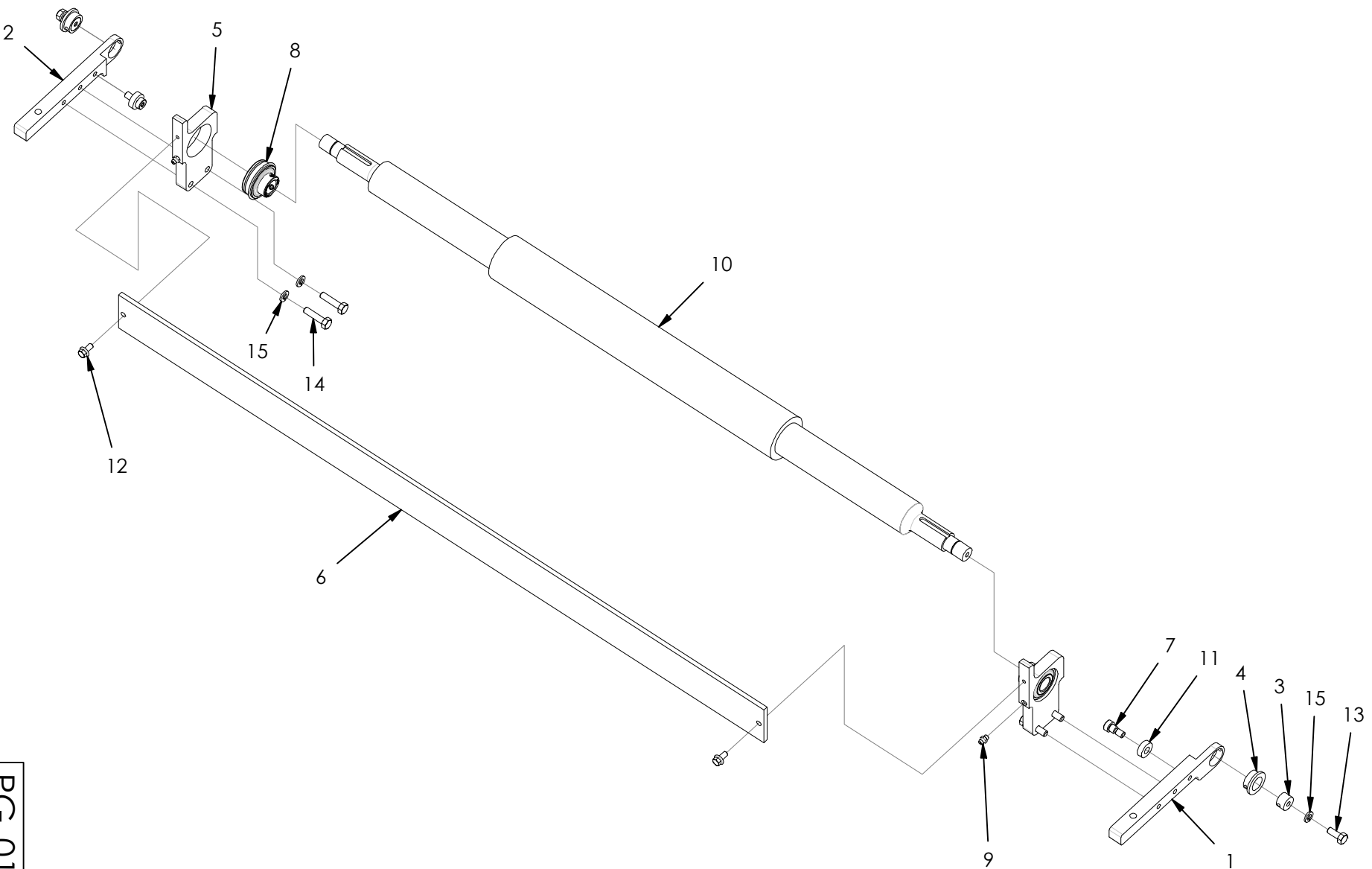
1501-A001 Gear Box Sub-Assembly



1501-A001 Gear Box Sub-Assembly

ITEM	PART NUMBER	DESCRIPTION	QTY
1	1501-0002A	Gear Box Assembly	1
2	1501-0101	Gearbox Mount	1
3	1501-0102	Motor Mount	1
4	1501-0103HC	Spacer	4
5	1501-0107CH	Tension Mount	1
6	1501-0108	Stud	1
7	1501-0115HC	Spacer	1
8	1511-0052HC	Drive Cog Coupling	1
9	9200-0038	Bearing	2
10	9200-0043	Tension Idler	1
11	9201-0001H	Servo Motor	1
12	9201-0005	3/4-1 Servo Coupling Assembly	1
13	9201-0008	Drive Cog	1
14	9211-0062	Key (1/4" X 1")	2
15	9500-62	Washer	1
16	9502-0265EX	Key (6X6X30)	1
17	1/4-20X1SHDP	Dog Point Socket Head Bolt	2
18	5/16-18X1 1/8SHDP	Dog Point Socket Head Bolt	1
19	5/16-18X3/4HH	Hex Head Bolt	2
20	3/8-16X1HH	Hex Head Bolt	4
21	3/8-16X1 1/4HH	Hex Head Bolt	8
22	3/8-16X1 1/2HH	Hex Head Bolt	2
23	3/8-16X2 3/4HH	Hex Head Bolt	4
24	5/16-18X3/8SS	Set Screw	1
25	5/16-18X3/4SH	Socket Head Bolt	1
26	5/16LW	Lock Washer	3
27	3/8LW	Lock Washer	18
28	3/4EXT	Snap Ring	2
29	1 3/4INT	Snap Ring	1
30	M10-1.5X30SH	Socket Head Bolt	2
95	9218-0034	Motor Cable	0
96	9218-0035 WQ	Encoder Cable	0
97	9501-0005RW -4	Coupling Hub, 3/4"	0
98	9501-000RW -1	Coupling Hub, 1"	0
99	9502-0261S -2	Coupling Insert	0

1501-A002 Nip Roller Sub-Assembly



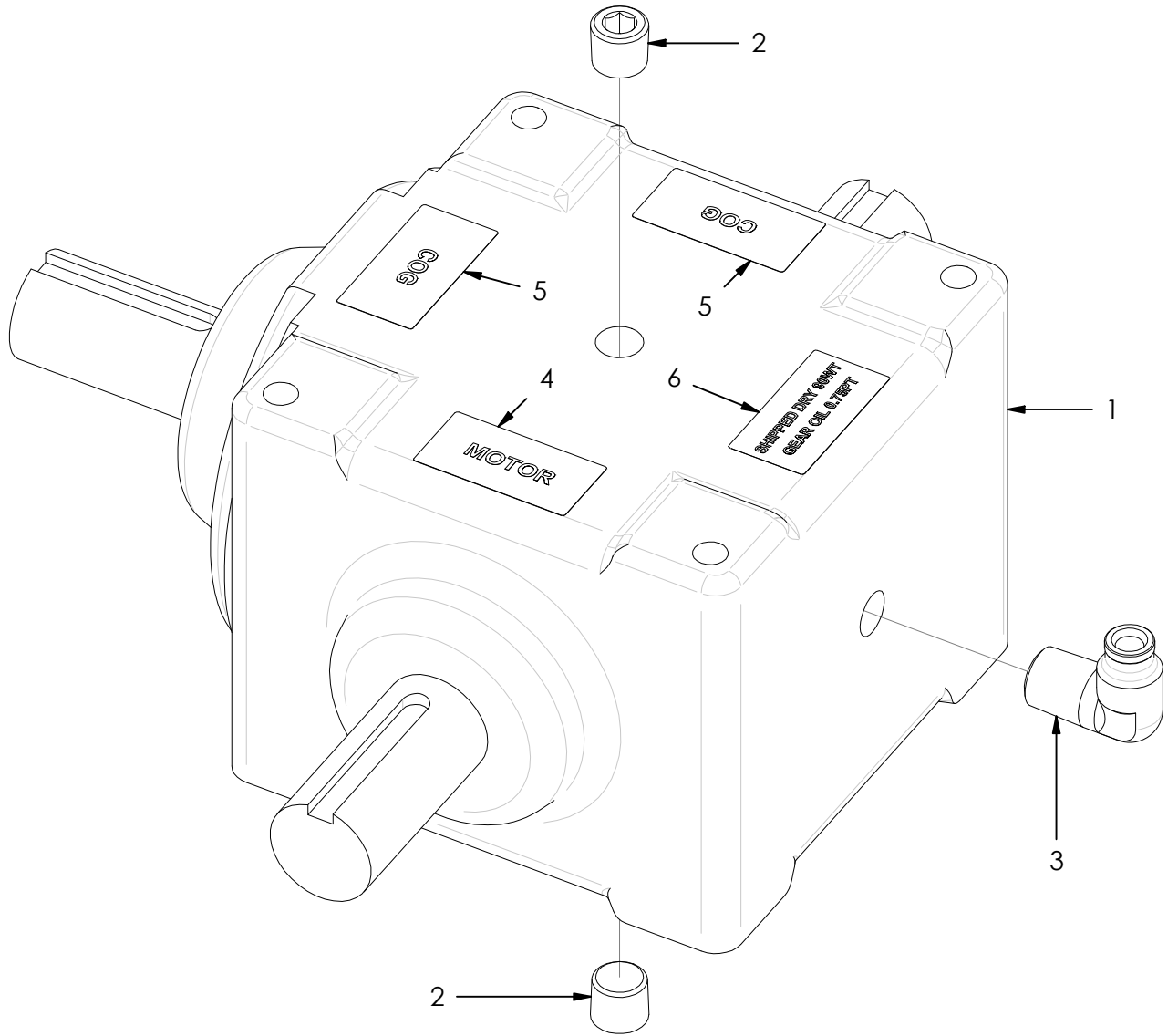
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1501-A002 Nip Roller Sub-Assembly

ITEM	PART NUMBER	DESCRIPTION	QTY
1	1501-0011L	Support Arm	1
2	1501-0011R	Support Arm	1
3	1501-0028	Pivot Stud	2
4	1501-0037	Bushing	2
5	1501-0074	Plate	2
6	1501-0100	Nip Guard	1
7	1501-0116	Shoulder Bolt	2
8	9200-0050SS	Bearing	2
9	9203-0063	Grease Zerk	2
10	9501-0007TD2-18A	Nip Roller	1
11	9508-0084	Pressure Ring	2
12	1/4-20X1/2FB	Flange Bolt	2
13	5/16-18X3/4HH	Hex Head Bolt	2
14	5/16-18X1 1/4HH	Hex Head Bolt	4
15	5/16LW	Lock Washer	6

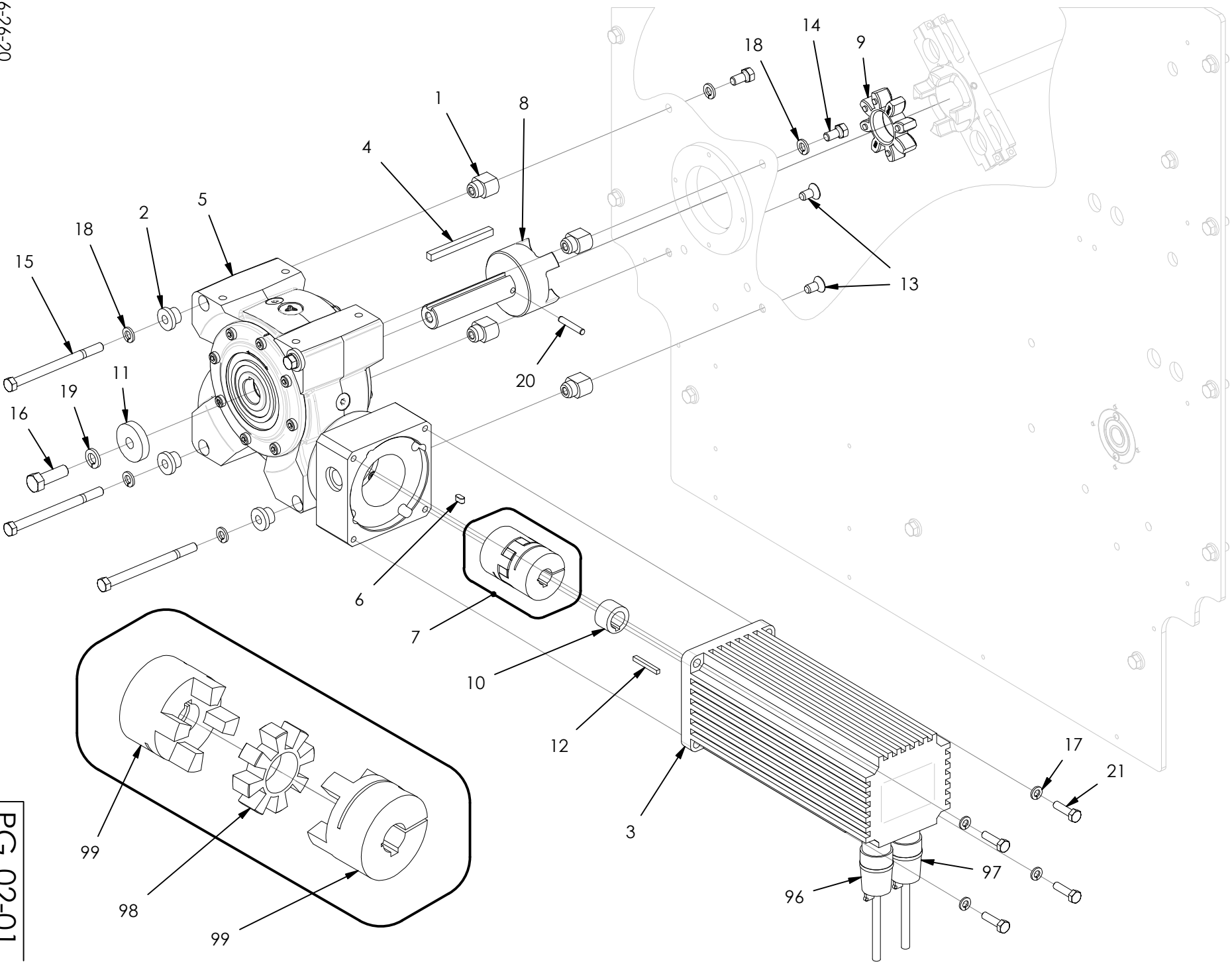
1501-0002A Gear Box Assembly



1501-0002A Gear Box Assembly

ITEM	PART NUMBER	DESCRIPTION	QTY
1	1501-0002	Gearbox	1
2	9200-0085SS	1/4" Pipe Plug	2
3	9500-140	Air Fitting	1
4	9516-0025 -25	Motor LP	1
5	9516-0025 -36	Cog LP	2
6	9516-0025 -38	Shipped Dry 90WT Gear Oil LP	1

1502RMPP Power Pack Assembly



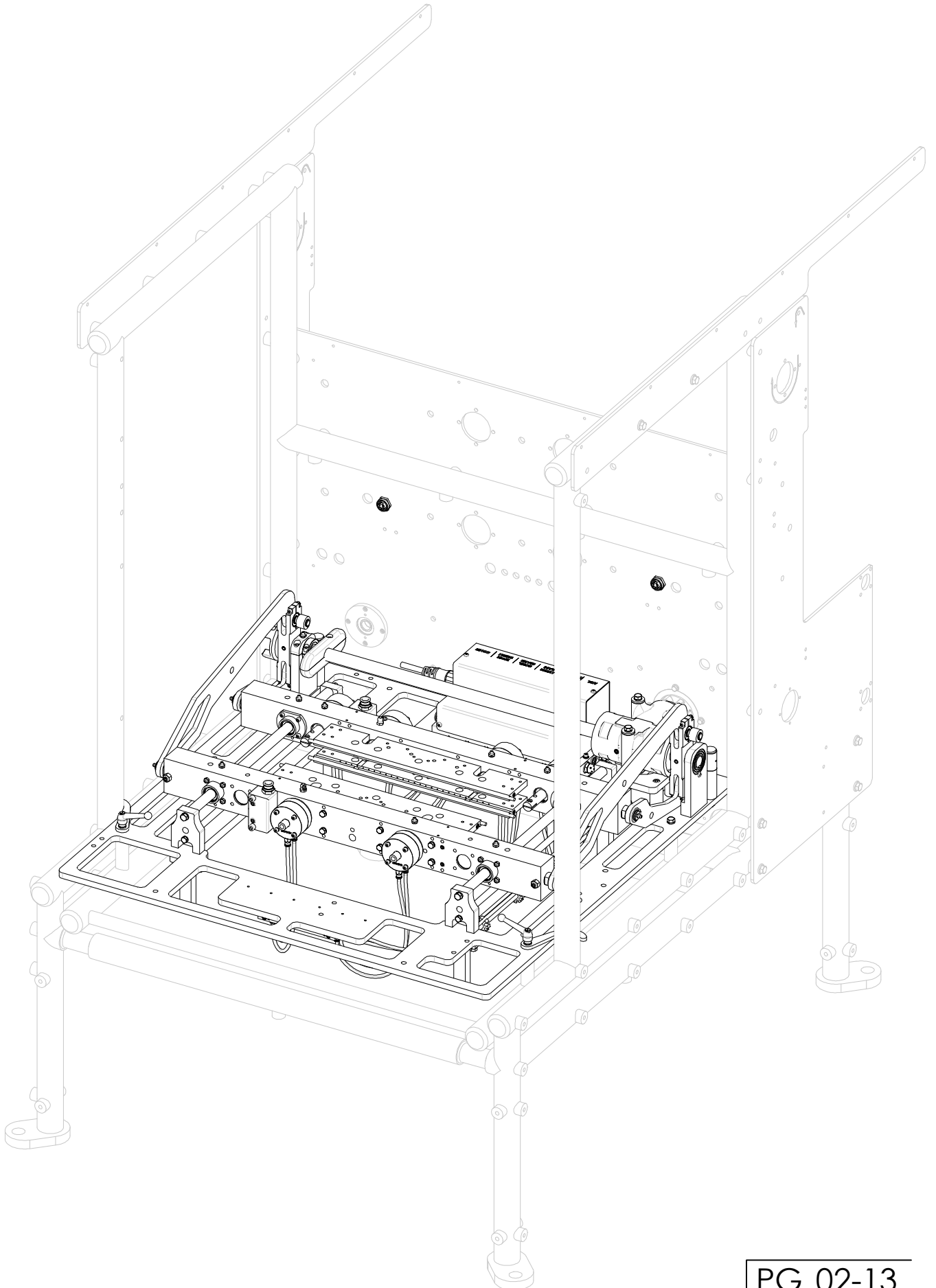
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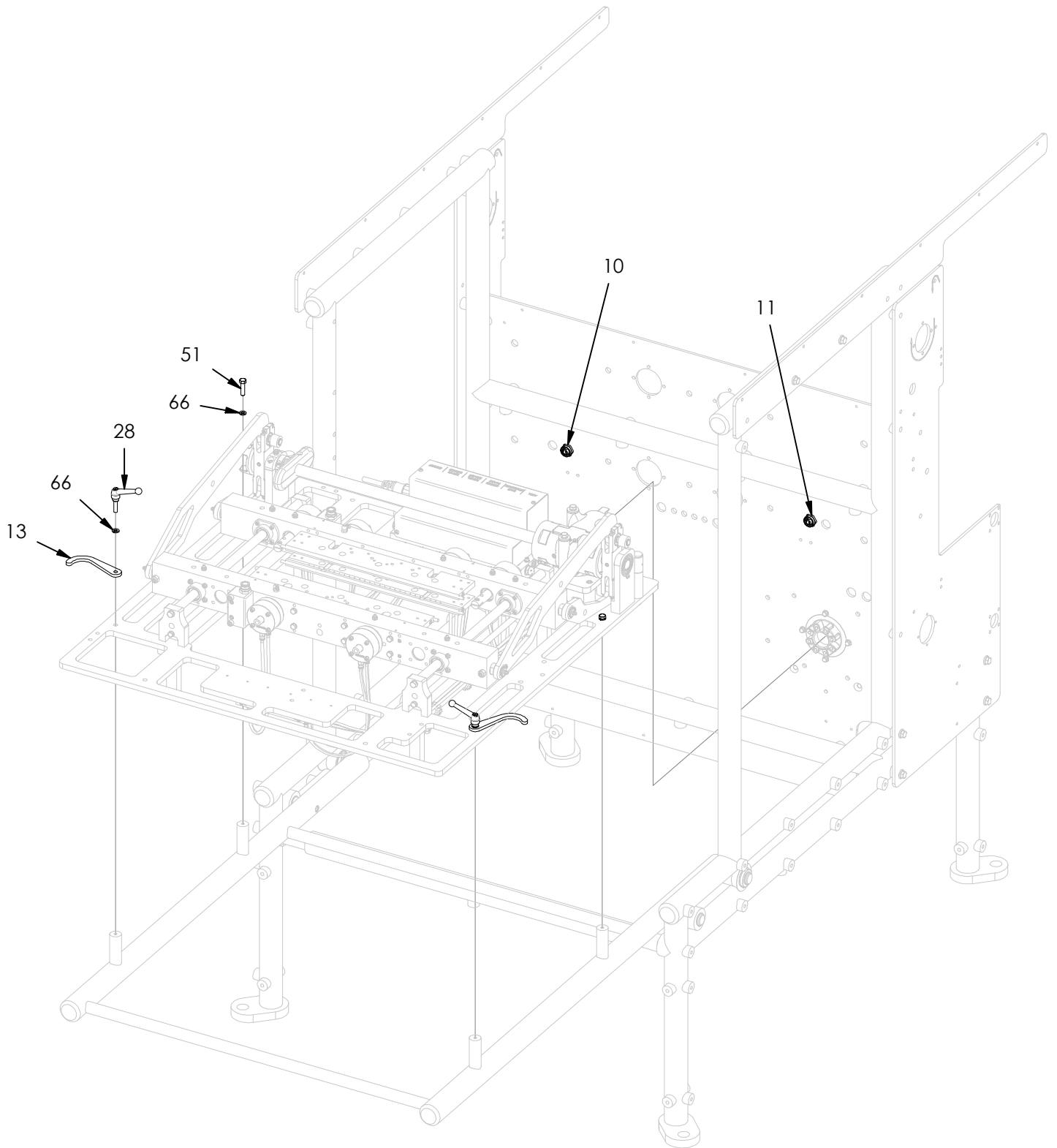
1502RMPP Power Pack Assembly

ITEM	PART NUMBER	DESCRIPTION	QTY
1	1501-0105	Spacer	4
2	1501-0106	Washer	4
3	9201-0001H	Servo Motor	1
4	9502-0211RM	Key	1
5	9502-0212RMV2	Gearbox Assembly	1
6	9502-0212RMV2 -1	Key	1
7	9502-0213RMV2	Coupling	1
8	9502-0261S	Coupling Shaft Assembly	1
9	9502-0261S -2	Coupling Insert	1
10	9502-0262RM	Motor Coupling Spacer	1
11	9502-0263RM	Washer	1
12	9502-0265EX	Key (6X6X30)	1
13	3/8-16X3/4FH	Flat Head Bolt	2
14	3/8-16X3/4HH	Hex Head Bolt	2
15	3/8-16X5HH	Hex Head Bolt	4
16	1/2-13X1 1/2HH	Hex Head Bolt	1
17	5/16LW	Lock Washer	4
18	3/8LW	Lock Washer	6
19	1/2LW	Lock Washer	1
20	1/4X1 1/2DP	Dowel Pin	1
21	M8X30HH	Hex Head Bolt	4
96	9218-0034	Motor Cable	0
97	9218-0035 WQ	Encoder Cable	0
98	9502-0213RM -2	Coupling Insert	0
99	9502-0213RMV2 -1	Female Coupling Hub	0

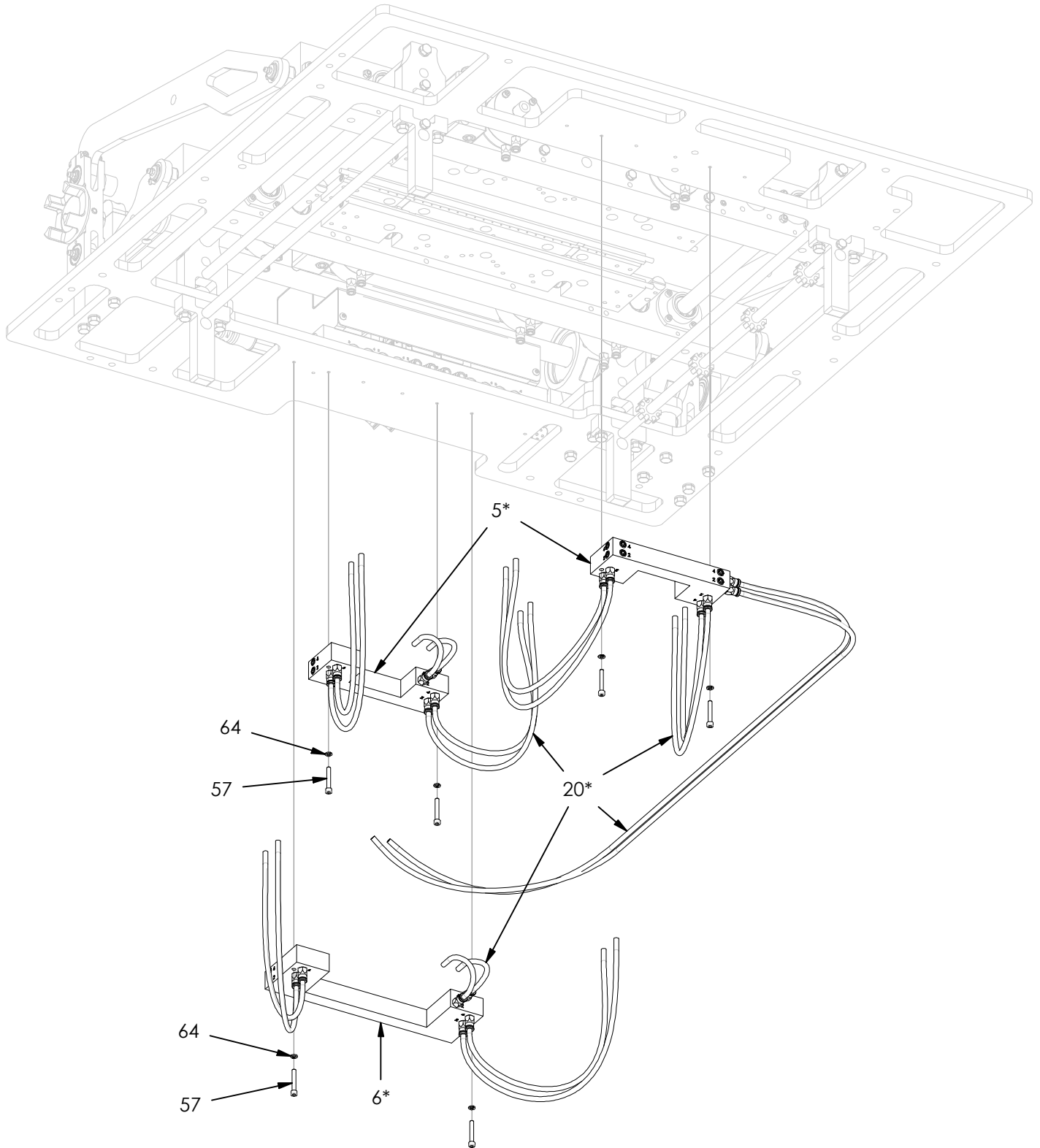
1502RMPB4 Rear Mount Servo Jaw Assembly



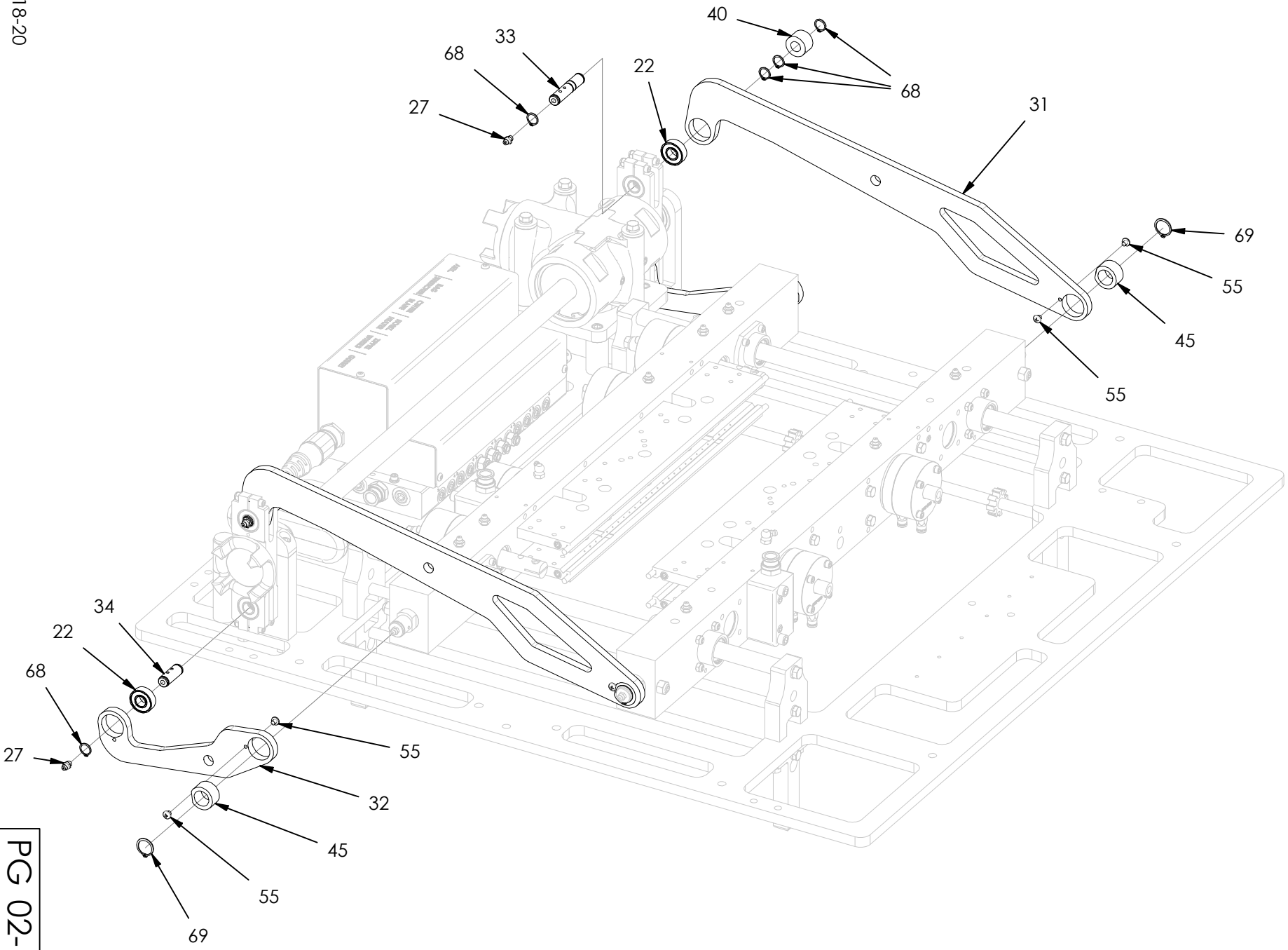
1502RMPB4 Rear Mount Servo Jaw Assembly



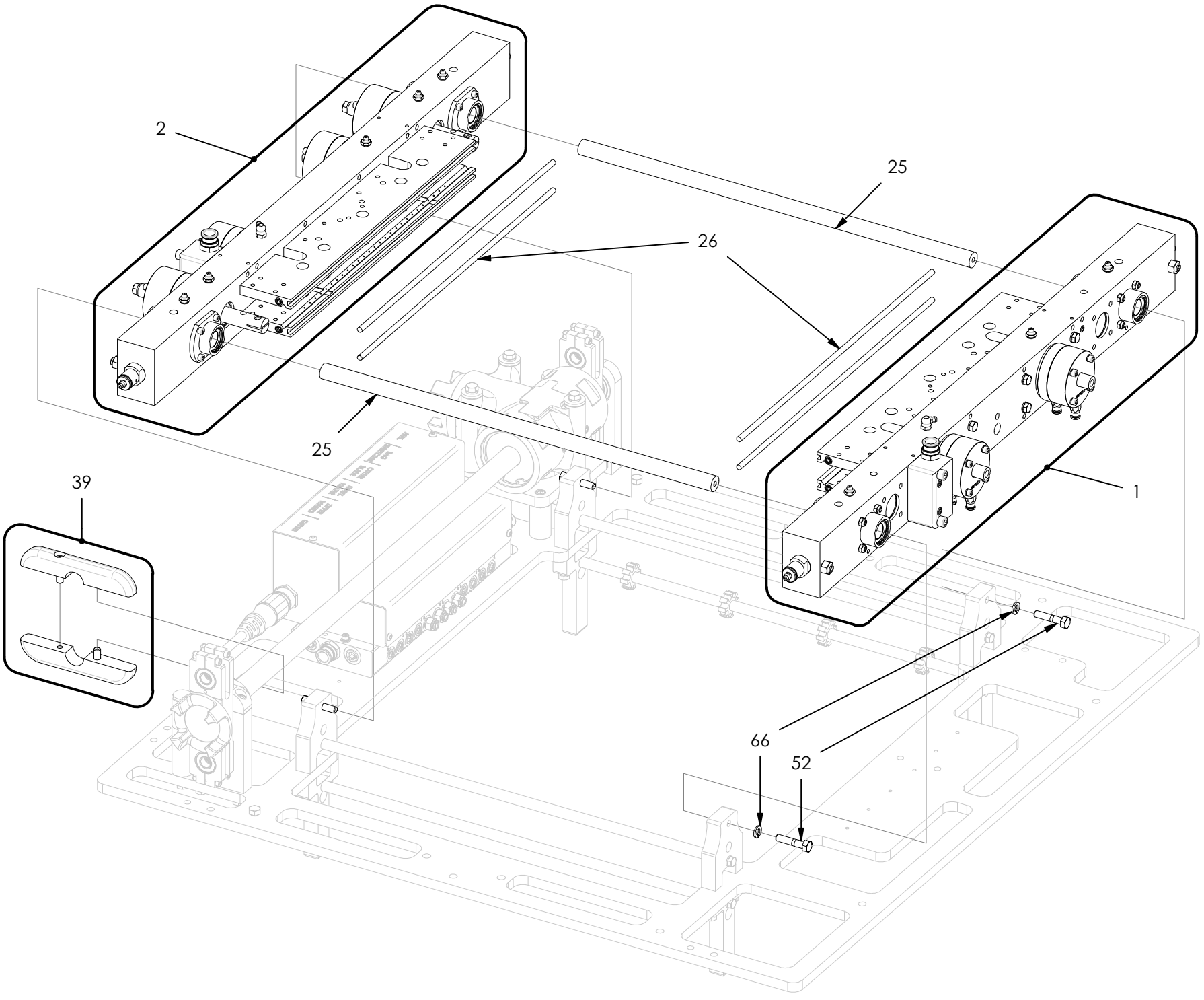
1502RMPB4 Rear Mount Servo Jaw Assembly



1502RMPB4 Rear Mount Servo Jaw Assembly

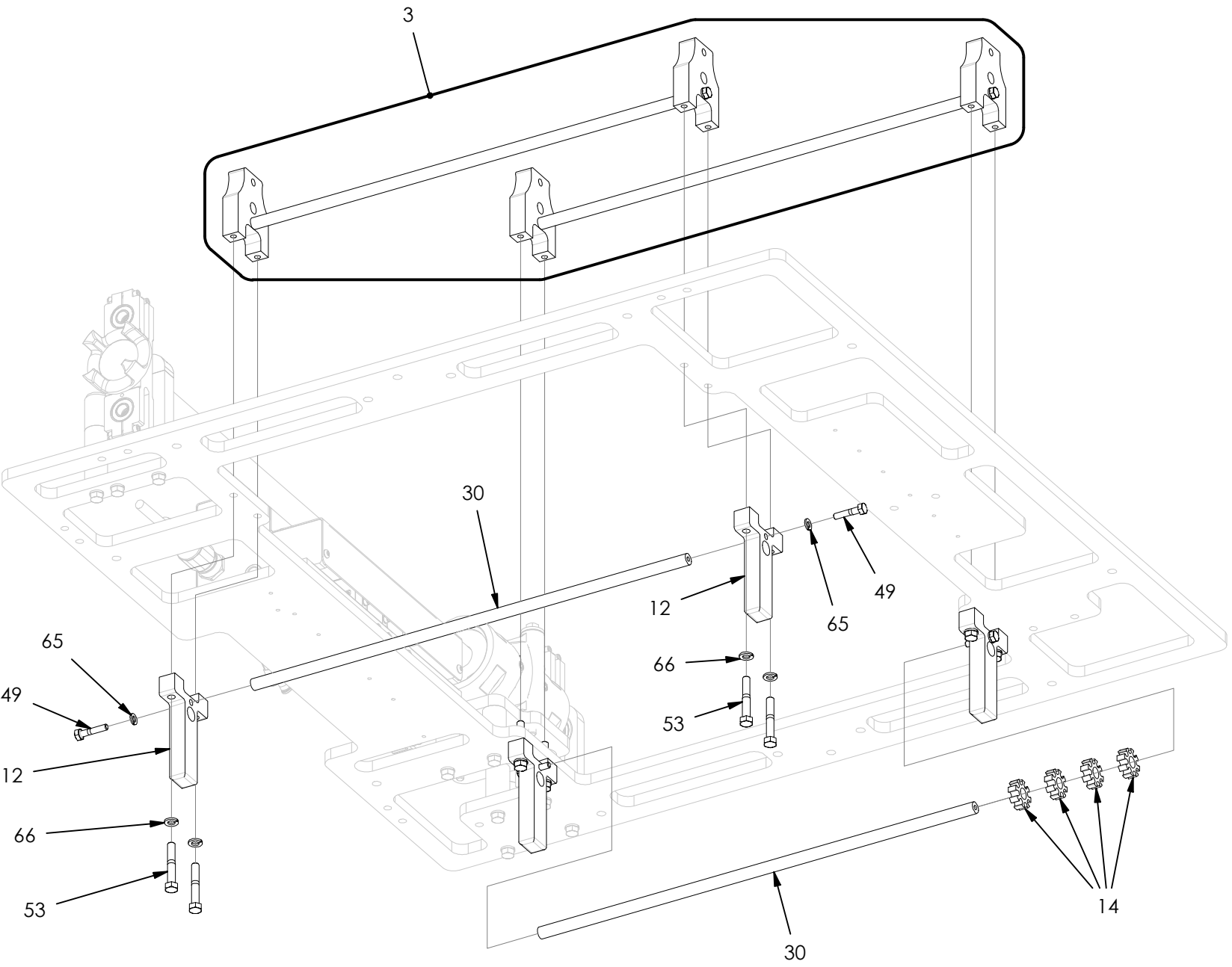


1502RMPB4 Rear Mount Servo Jaw Assembly

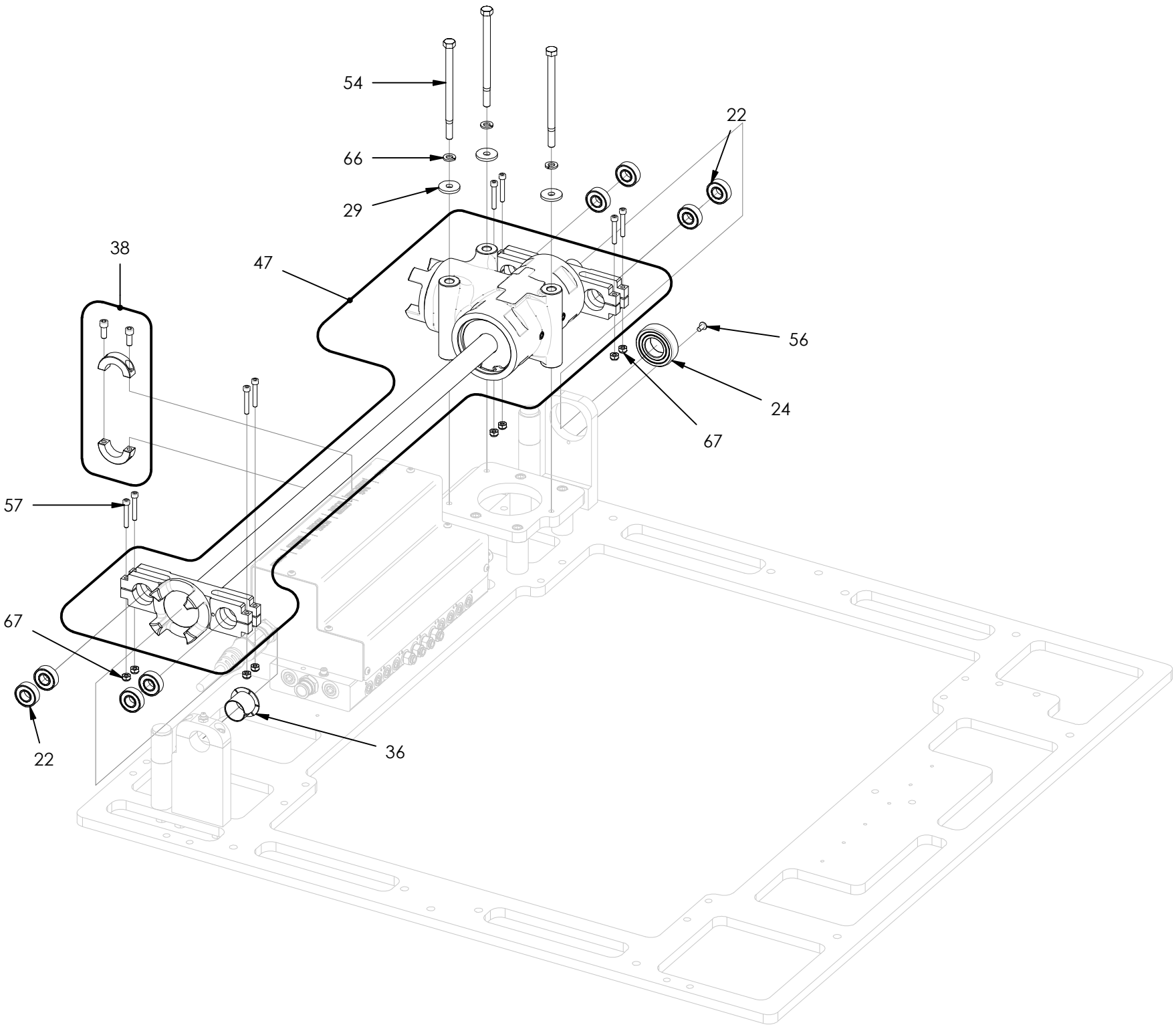


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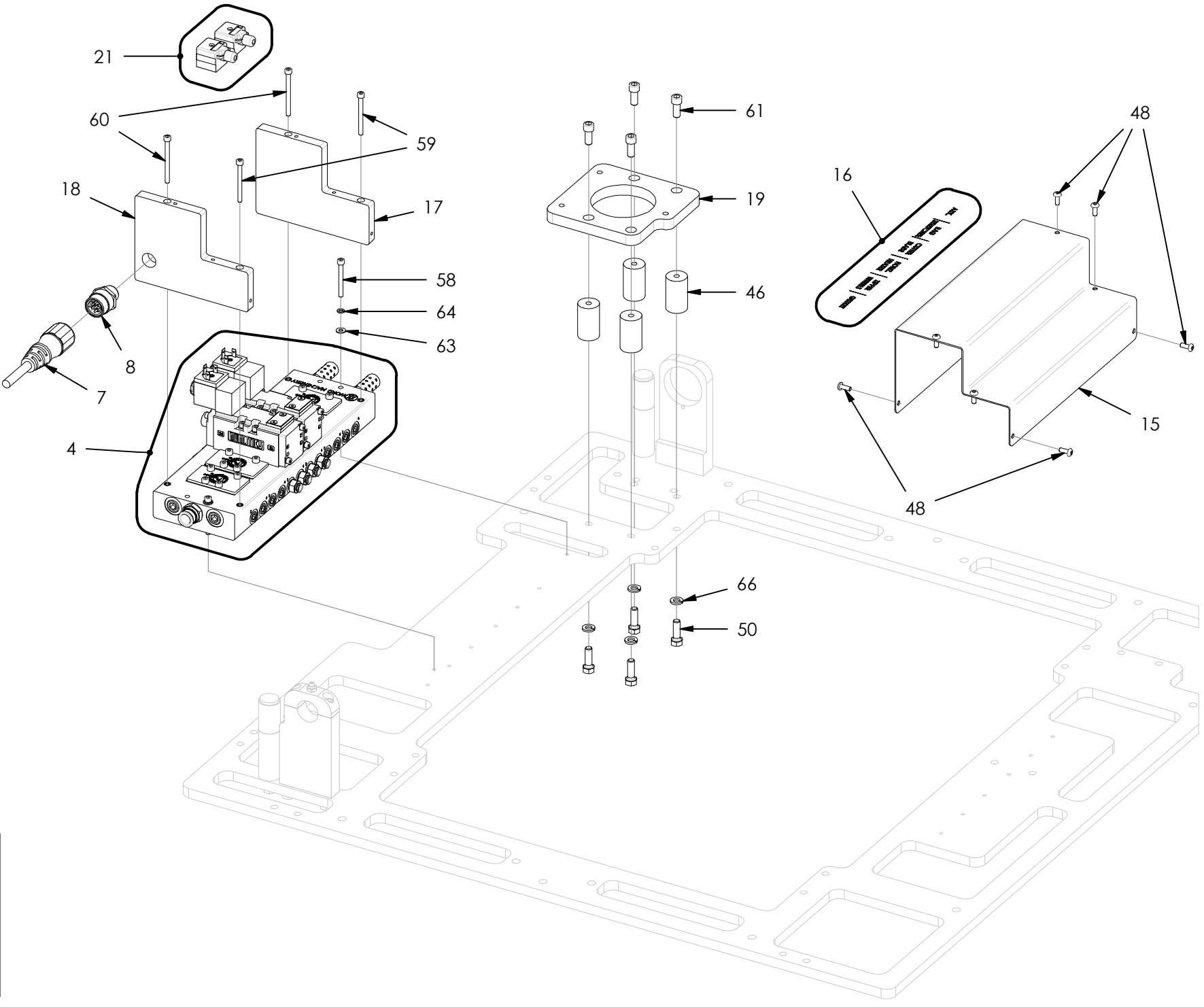
1502RMPB4 Rear Mount Servo Jaw Assembly



1502RMPB4 Rear Mount Servo Jaw Assembly

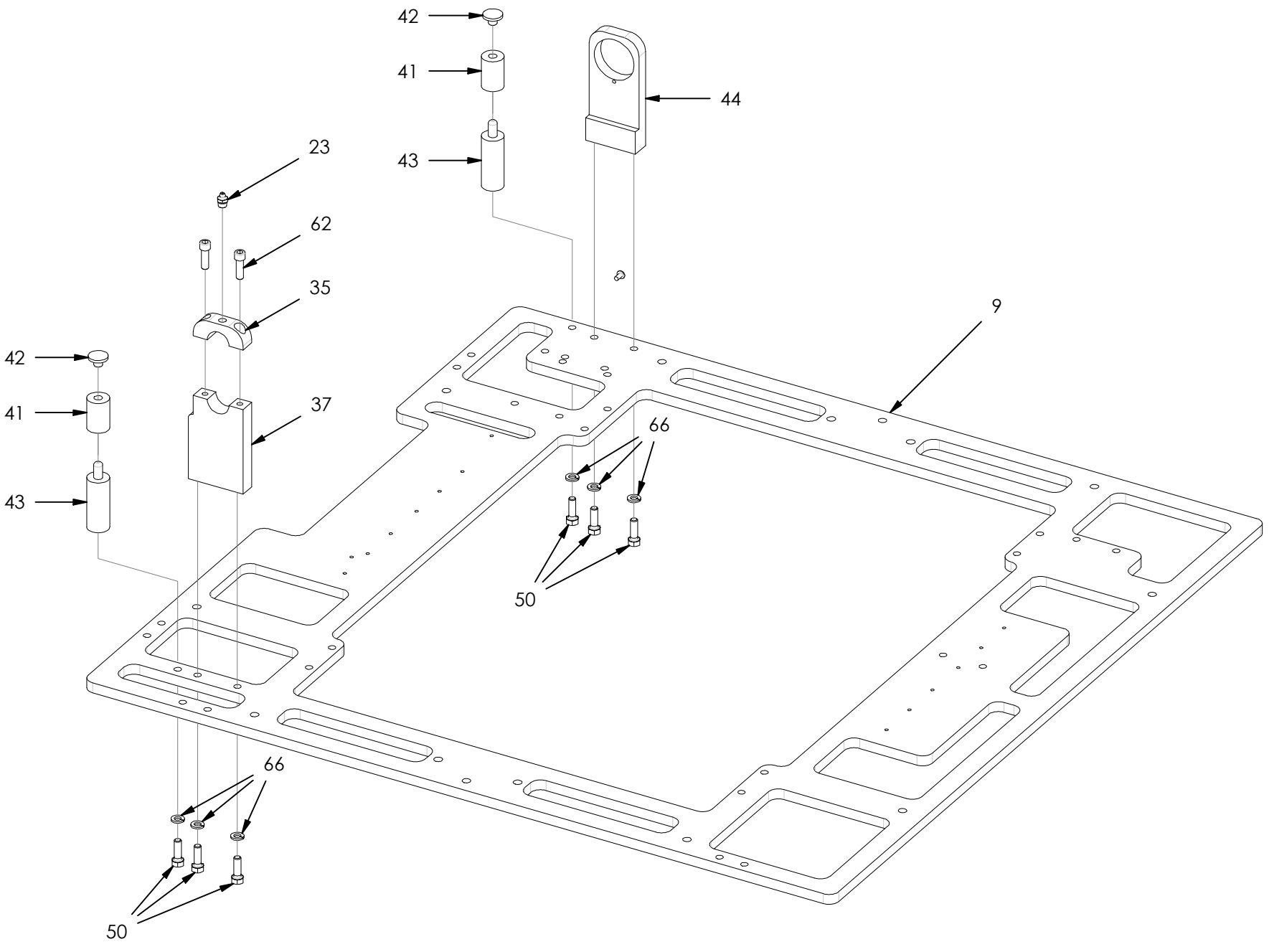


1502RMPB4 Rear Mount Servo Jaw Assembly



12-18-20

1502RMPB4 Rear Mount Servo Jaw Assembly



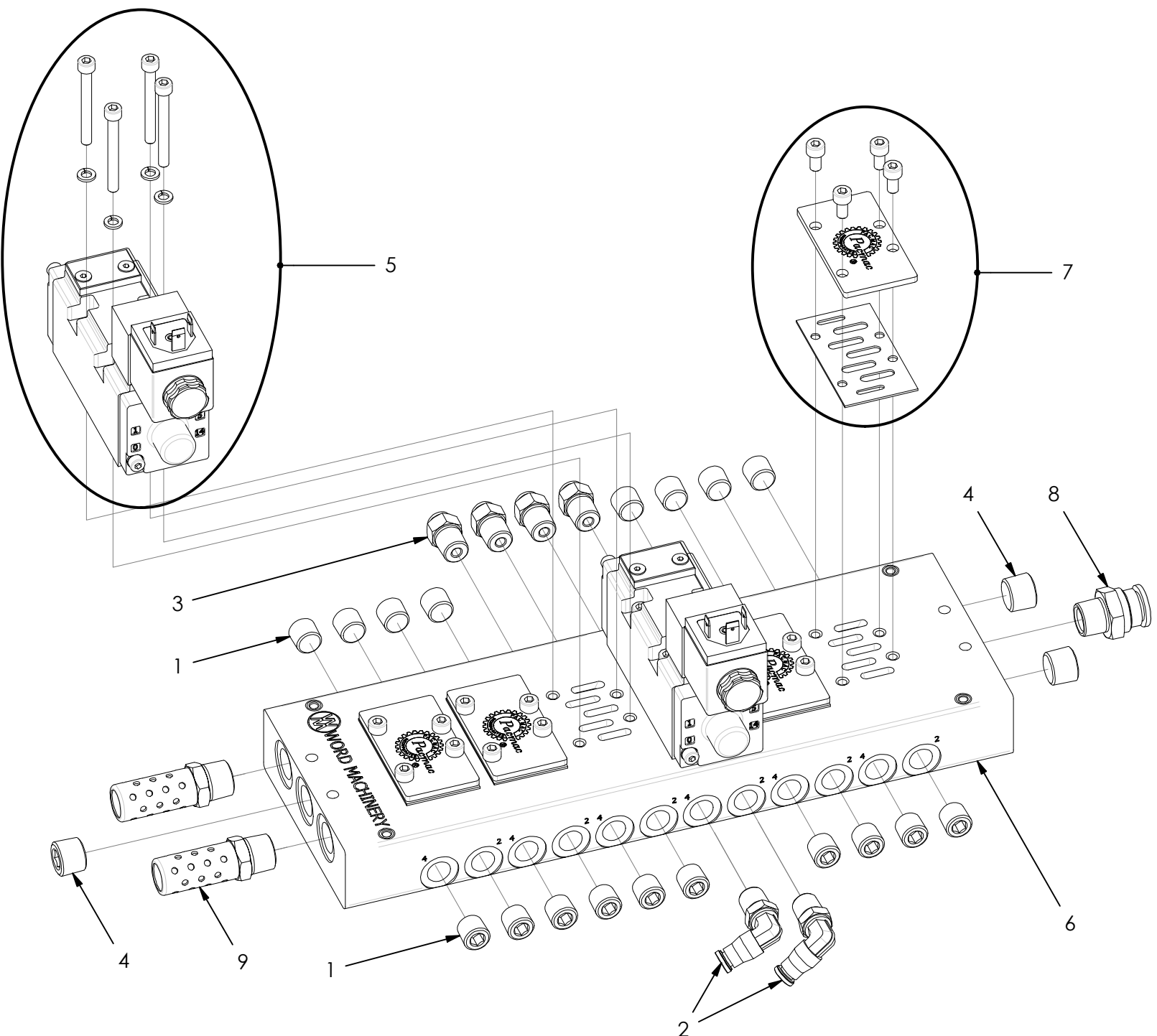
1502RMPB4 Rear Mount Servo Jaw Assembly

ITEM	PART NUMBER	DESCRIPTION	QTY
1	1502-W005 -LH-RM	Lower Jaw Sub-Assembly	1
2	1502-W006 -RH-RM	Lower Jaw Sub-Assembly	1
3	9502-A008SJ	Linear Shaft Support Sub-Assy	1
4	9502NM-6-2	Jaws Air Valve Assembly	1
5	A9502-0282	Manifold Assembly	1
6	A9502-0283	Manifold Assembly	1
7	1518-W221UL -1	Jaw Valve Control Cable	0
8	1502-0097	Male Receptacle	1
9	1502-0100RM2	Worktable	1
10	1502-0118HUL-L	Horizontal Heater Cable	0
11	1502-0118HUL-R	Horizontal Heater Cable	0
12	1502-0284	Foot	4
13	1502-0301	Worktable Lock	2
14	1502-0304	Airline Support	4
15	1502-0305	Cover	1
16	1502-0305 -3	Jaw Valve Legend Decal	1
17	1502-0306	End Plate	1
18	1502-0307	End Plate	1
19	1502-0308	Adapter Plate	1
20	1502-A004	Jaw Tubing Kit	1
21	1502-A009	Connector Kit	1
22	9200-0057FC	Bearing	12
23	9200-0069	Grease Zerk	1
24	9201-0067	Bearing	1
25	9202-0018	Linear Shaft	2
26	9202-0054	Gripper Cord	4
27	9203-0063	Grease Zerk	4
28	9207-0032	Handle	2
29	9500-62	Washer	3
30	9502-0117	Shaft	2
31	9502-0202TS	Long Mayme Lever	2
32	9502-0203TS	Short Mayme Lever	2
33	9502-0204V2B -3	Pin	2
34	9502-0204V2B -4	Pin	2
35	9502-0207W -1	Bearing Support Cap	1
36	9502-0207W -2	Split Bushing	1
37	9502-0207WRM	Bearing Support	1
38	9502-0208 -1	Shaft Collar	1
39	9502-0209RM	Handwheel	1
40	9502-0250 -4	Bumper	2

1502RMPB4 Rear Mount Servo Jaw Assembly

ITEM	PART NUMBER	DESCRIPTION	QTY
41	9502-0250V2 -1	Spring	2
42	9502-0250V2 -2	Cap	2
43	9502-0250V2RM	Stud	2
44	9502-0251	Bearing Support	1
45	9502-0252SS -1	Bushing	4
46	9502-0258RM	Gearbox Spacer	4
47	A9502-0257ANV4	Gearbox Assembly	1
48	10-32X1/2BH	Button Head Screw	8
49	1/4-20X1 1/4HH	Hex Head Bolt	4
50	5/16-18X1HH	Hex Head Bolt	10
51	5/16-18X1 1/4HH	Hex Head Bolt	2
52	5/16-18X1 1/2HH	Hex Head Bolt	4
53	5/16-18X2HH	Hex Head Bolt	8
54	5/16-18X5HH	Hex Head Bolt	3
55	10-32X3/16PPH	Phillips Pan Head Screw	8
56	10-32X3/8PPH	Phillips Pan Head Screw	1
57	10-32X1 1/4SH	Socket Head Bolt	14
58	10-32X1 3/4SH	Socket Head Bolt	2
59	10-32X2SH	Socket Head Bolt	2
60	10-32X2 1/4SH	Socket Head Bolt	2
61	5/16-18X3/4SH	Socket Head Bolt	4
62	5/16-18X1SH	Socket Head Bolt	2
63	#10FW	Flat Washer	2
64	#10LW	Lock Washer	8
65	1/4LW	Lock Washer	4
66	5/16LW	Lock Washer	29
67	10-32LN	Lock Nut	8
68	1/2EXT	Snap Ring	12
69	3/4EXT	Snap Ring	4

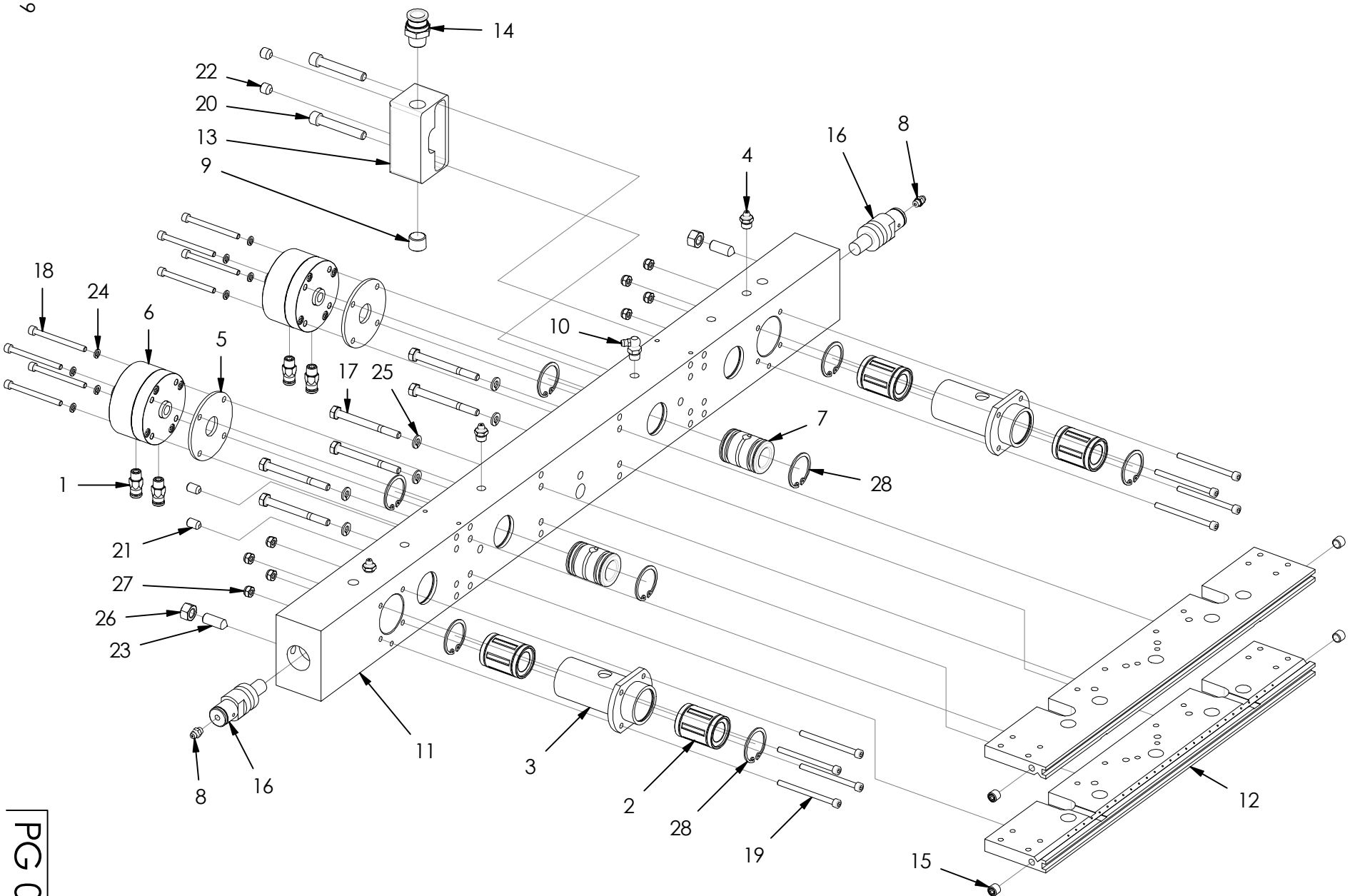
9502NM-6-2 Jaws Air Valve Assembly



9502NM-6-2 Jaws Air Valve Assembly

ITEM	PART NUMBER	DESCRIPTION	QTY
1	9200-0085SS	1/4" Pipe Plug	18
2	9203-0023	Tubing Connector	2
3	9216-0016	Tubing Connector	4
4	9216-0047SS	3/8" Pipe Plug	3
5	9500-77NM	Valve Body - Numatics	2
6	9500-82RX -6	Six Station Manifold	1
7	9500-85	Stainless Blanking Station	4
8	9502-0068	Tubing Connector	1
9	9517-0011	Exhaust Muffler	2

1502-A005 -LH-RM Lower Jaw Sub-Assembly



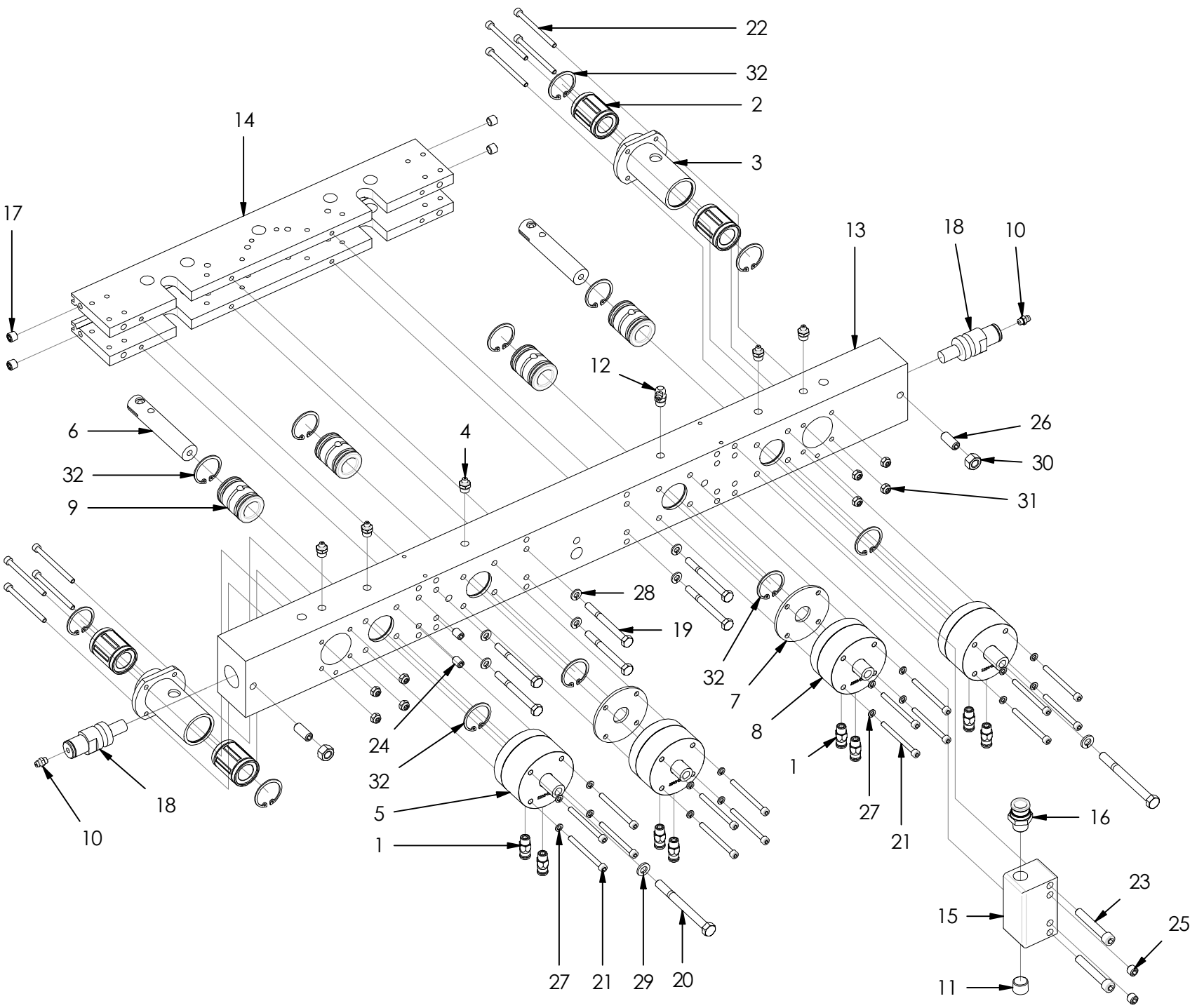
10-18-19

PG 02-26

1502-A005 -LH-RM Lower Jaw Sub-Assembly

ITEM	PART NUMBER	DESCRIPTION	QTY
1	9200-0034	Tubing Connector	4
2	9200-0059	Linear Bearing	4
3	9200-0061RM	Bearing Sleeve	2
4	9200-0069	Grease Zerk	3
5	9202-0028	Cylinder Insulator	2
6	9202-0037	Air Cylinder	2
7	9202-0058	Bushing	2
8	9203-0063	Grease Zerk	2
9	9216-0047SS	3/8" Pipe Plug	1
10	9501-0099	Grease Zerk	1
11	9502-0001RM	Jaw	1
12	9502-0007	Cooling Plate	2
13	9502-0007M	Manifold	1
14	9502-0068	Tubing Connector	1
15	9502-0125S	1/8" Pipe Plug	4
16	9502-0252SS	Stud	2
17	1/4-20X2 3/4HH	Hex Head Bolt	6
18	10-32X2 1/4SH	Socket Head Bolt	8
19	10-32X2 1/2SH	Socket Head Bolt	8
20	5/16-18X2SH	Socket Head Bolt	2
21	5/16-18X1/2SS	Set Screw	2
22	3/8-16X3/8SS	Set Screw	2
23	3/8-16X1SS CP	Cone Point Set Screw	2
24	#10LW	Lock Washer	8
25	1/4LW	Lock Washer	6
26	3/8-16HN	Hex Nut	2
27	10-32LN	Lock Nut	8
28	1 1/4INT	Snap Ring	8

1502-A006 -RH-RM Lower Jaw Sub-Assembly



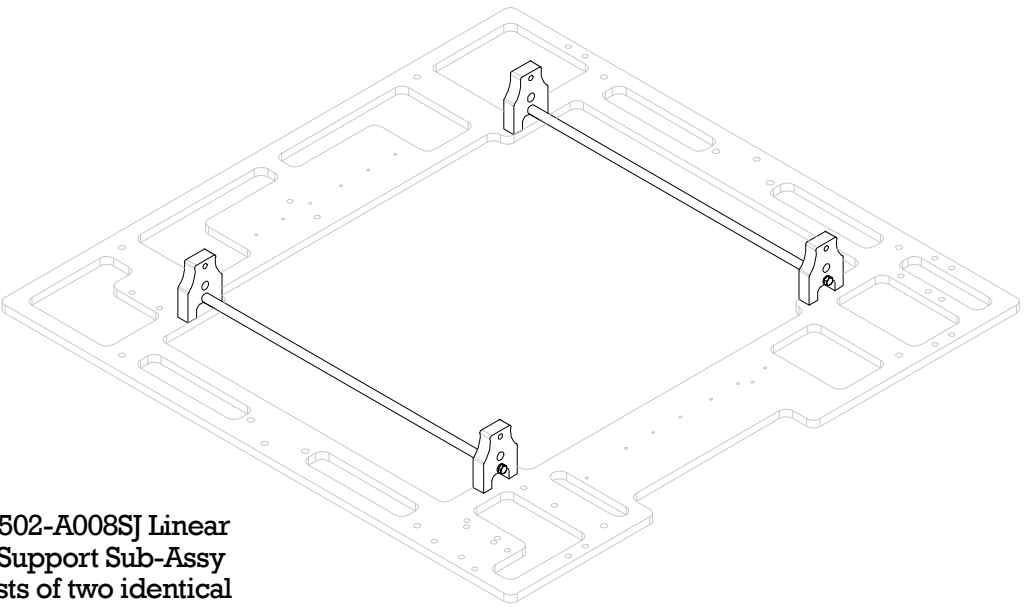
10-18-19

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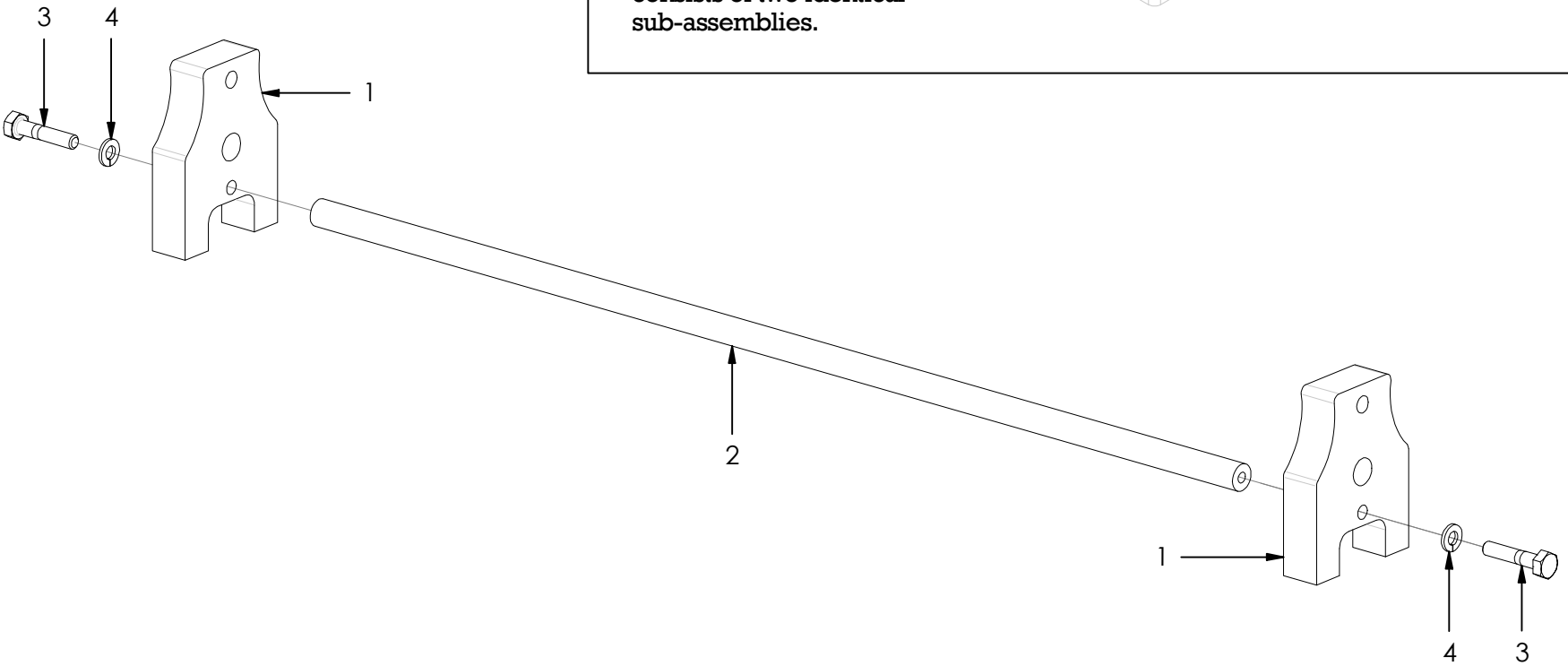
1502-A006 -RH-RM Lower Jaw Sub-Assembly

ITEM	PART NUMBER	DESCRIPTION	QTY
1	9200-0034	Tubing Connector	8
2	9200-0059	Linear Bearing	4
3	9200-0061RM	Bearing Sleeve	2
4	9200-0069	Grease Zerk	5
5	9202-0002	Air Cylinder	2
6	9202-0010	Knife Stud	2
7	9202-0028	Cylinder Insulator	2
8	9202-0037	Air Cylinder	2
9	9202-0058	Bushing	4
10	9203-0063	Grease Zerk	2
11	9216-0047SS	3/8" Pipe Plug	1
12	9501-0099	Grease Zerk	1
13	9502-0001RM	Jaw	1
14	9502-0007	Cooling Plate	2
15	9502-0007M	Manifold	1
16	9502-0068	Tubing Connector	1
17	9502-0125S	1/8" Pipe Plug	4
18	9502-0252SS	Stud	2
19	1/4-20X2 3/4HH	Hex Head Bolt	6
20	5/16-18X3 1/2HH	Hex Head Bolt	2
21	10-32X2 1/4SH	Socket Head Bolt	16
22	10-32X2 1/2SH	Socket Head Bolt	8
23	5/16-18X2SH	Socket Head Bolt	2
24	5/16-18X1/2SS	Set Screw	2
25	3/8-16X3/8SS	Set Screw	2
26	3/8-16X1SS CP	Cone Point Set Screw	2
27	#10LW	Lock Washer	16
28	1/4LW	Lock Washer	6
29	5/16LW	Lock Washer	2
30	3/8-16HN	Hex Nut	2
31	10-32LN	Lock Nut	8
32	1 1/4INT	Snap Ring	12

9502-A008SJ Linear Shaft Support Sub-Assy



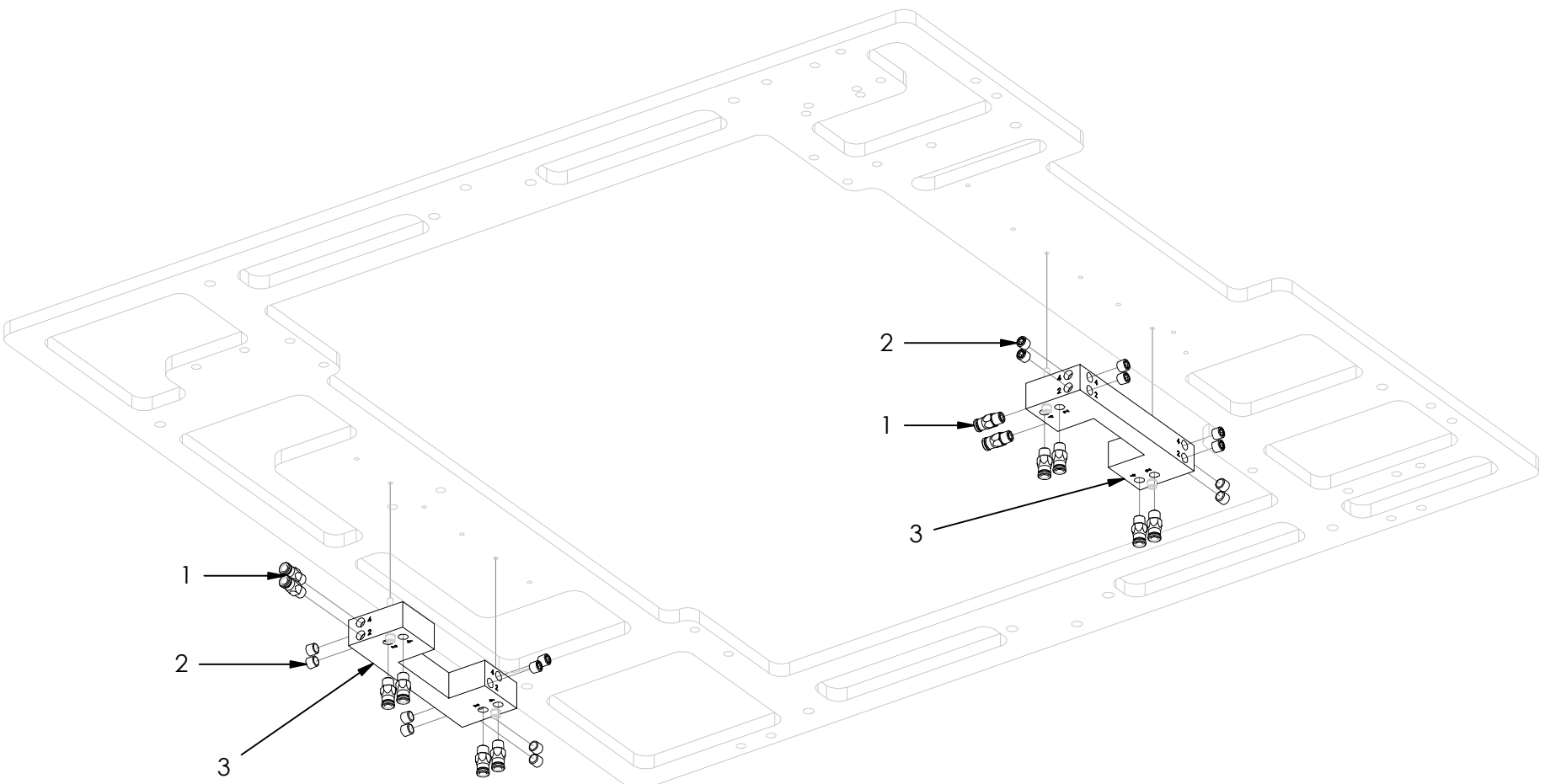
The 9502-A008SJ Linear Shaft Support Sub-Assy consists of two identical sub-assemblies.



9502-A008SJ Linear Shaft Support Sub-Assy

ITEM	PART NUMBER	DESCRIPTION	QTY
1	9502-0015SJ	Linear Shaft Support	4
2	9502-0117	Shaft	2
3	1/4-20X1 1/4HH	Hex Head Bolt	4
4	1/4LW	Lock Washer	4

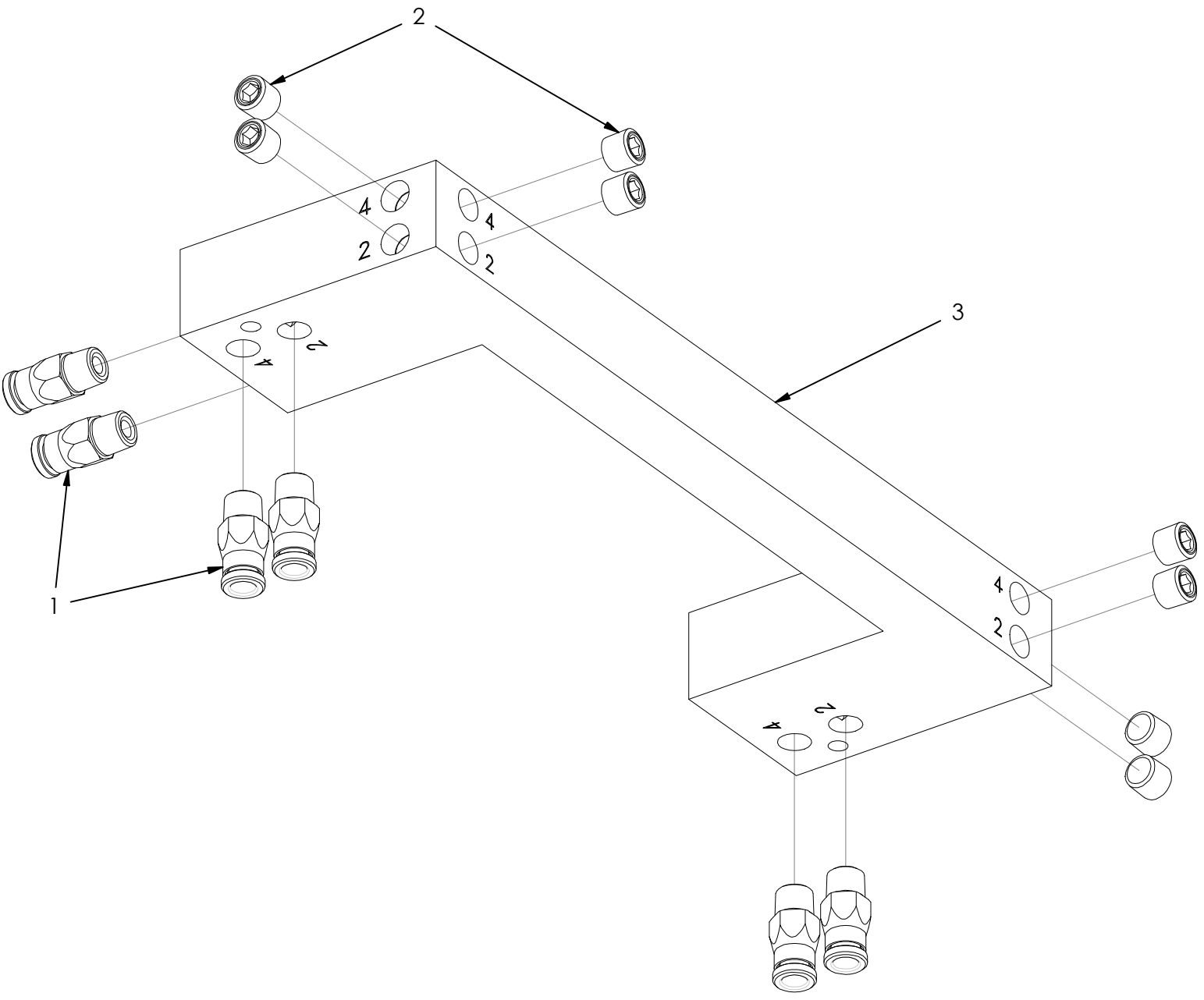
A9502-0282 Manifold Assembly



A9502-0282 Manifold Assembly

ITEM	PART NUMBER	DESCRIPTION	QTY
1	9200-0034	Tubing Connector	12
2	9502-0125S	1/8" Pipe Plug	16
3	9502-0282	Manifold	2

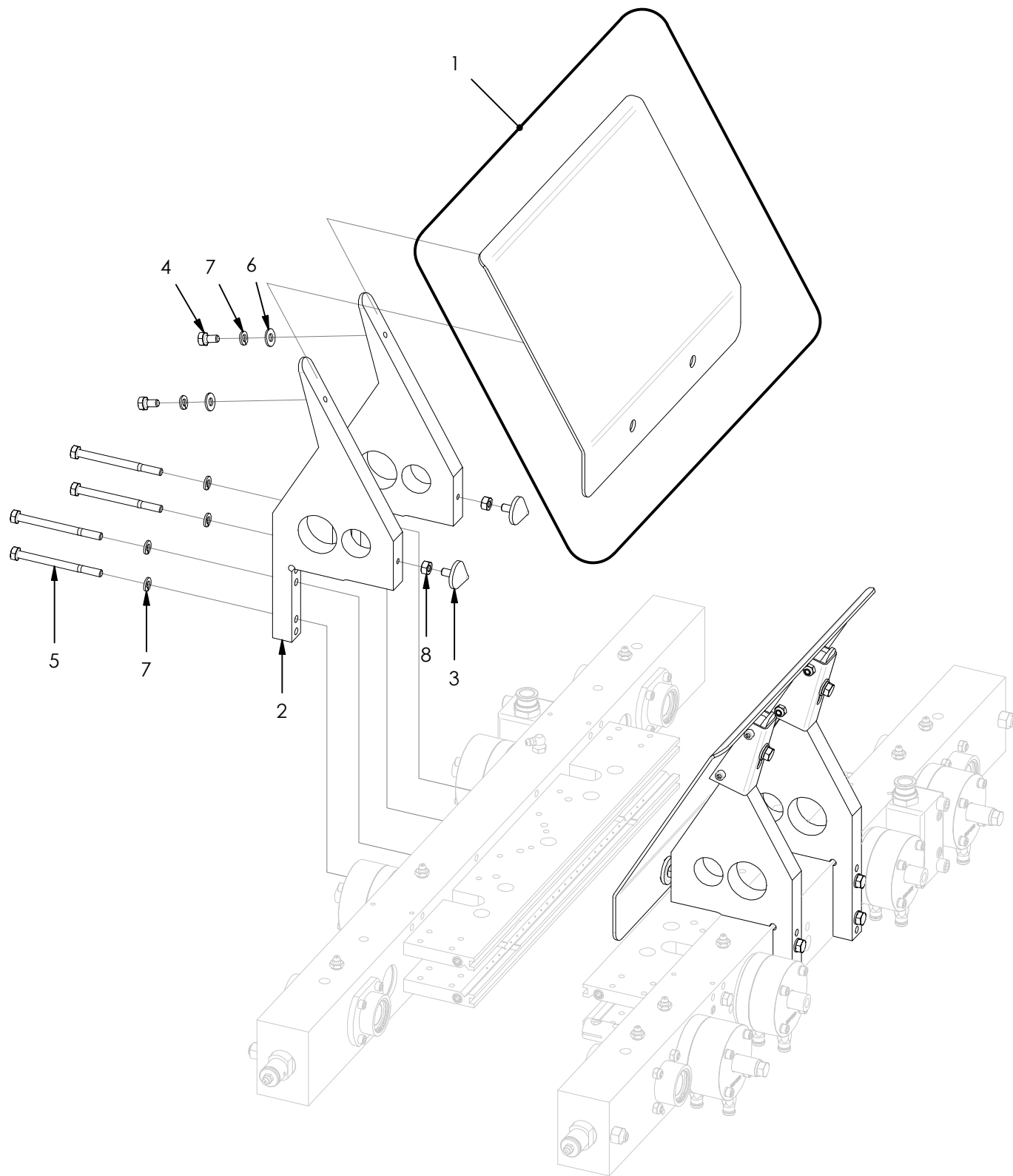
A9502-0283 Manifold Assembly



A9502-0283 Manifold Assembly

ITEM	PART NUMBER	DESCRIPTION	QTY
1	9200-0034	Tubing Connector	6
2	9502-0125S	1/8" Pipe Plug	8
3	9502-0283	Manifold	1

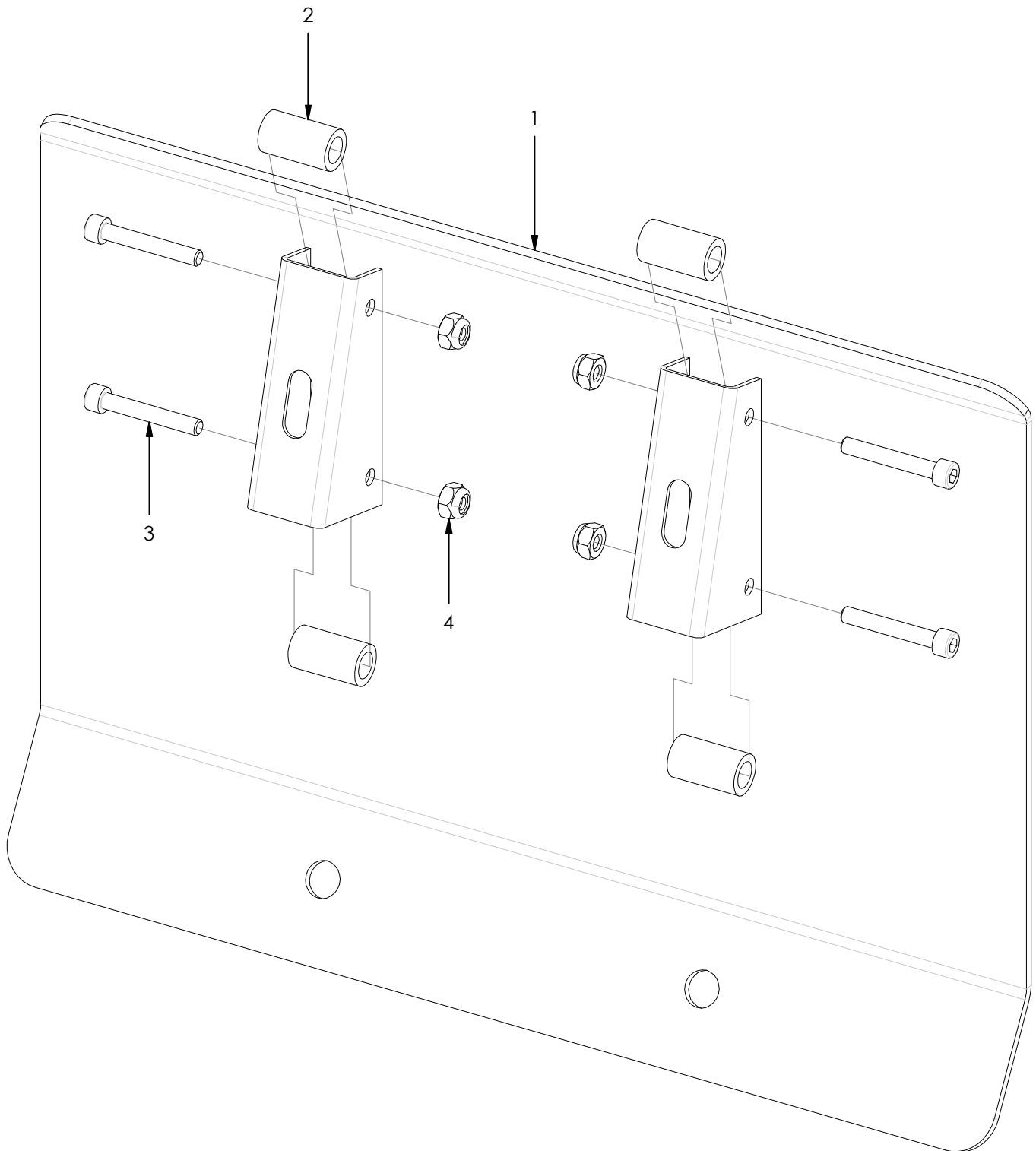
A1502-0076LQ -2 Skirt Clamp Assembly



A1502-0076LQ -2 Skirt Clamp Assembly

ITEM	PART NUMBER	DESCRIPTION	QTY
1	9502-0076LQ	Stager Assembly	2
2	9502-0075LQ -2	Brace	4
3	9502-0076LQ -1	Bumper	4
4	1/4-20X1/2HH	Hex Head Bolt	4
5	1/4-20X3 1/4HH	Hex Head Bolt	8
6	1/4FW	Flat Washer	4
7	1/4LW	Lock Washer	12
8	1/4-20HN	Hex Nut	4

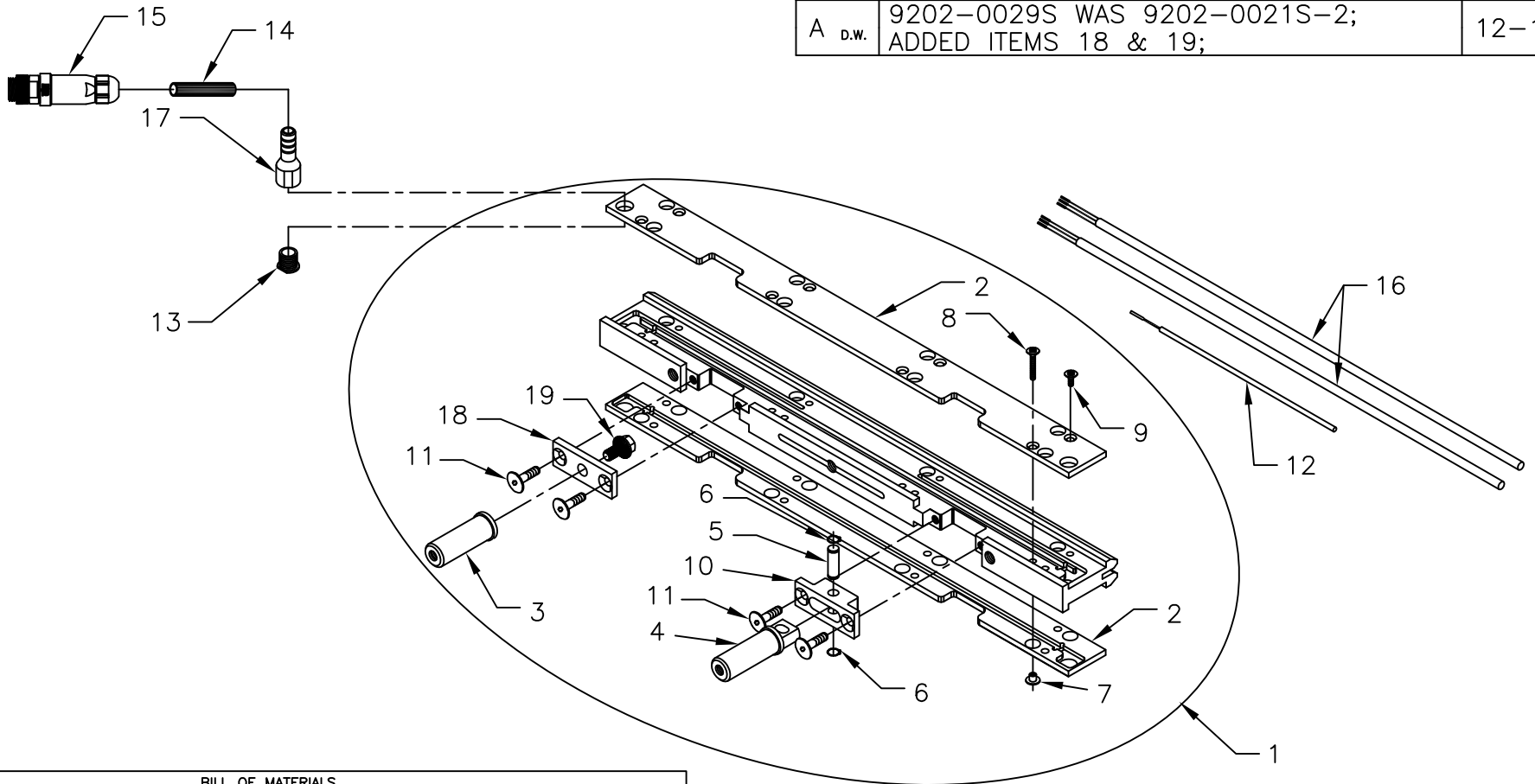
9502-0076LQ Stager Assembly



9502-0076LQ Stager Assembly

ITEM	PART NUMBER	DESCRIPTION	QTY
1	9502-0076LQ	Stager	1
2	9502-0076LQ-3	Tubing	4
3	10-32X1 1/4SH	Socket Head Bolt	4
4	10-32LN	Lock Nut	4

REVISION	DESCRIPTION	DATE
A D.W.	9202-0029S WAS 9202-0021S-2; ADDED ITEMS 18 & 19;	12-10-20



BILL OF MATERIALS

ITEM	PART NUMBER	DESCRIPTION	QTY
1	9202-0005PBSPV2	HEATER BAR	1
2	9202-0006SP-1	CAP	0
3 (A)	9202-0029S	HEATER BAR STUD	0
4	9202-0021S	HEATER BAR STUD	0
5	9202-0102	PIN	0
6	5/16EXT	SNAP RING	0
7	9500-120	BARREL NUT	0
8	8-32X7/8PFH	PHILLIPS FLAT HEAD	0
9	8-32X5/16PFH	PHILLIPS FLAT HEAD	0
10	9202-0004	HEATER BAR INSERT	0
11	1/4-20X5/8FH	FLAT HEAD BOLT	0
12	9200-0073	PROBE	1
13	9202-0120SP-1	STUD	1
14	9500-104	7/16" SILICONE TUBING	3'
15	9202-0074-4	MALE RECEPTACLE	1
16	9202-0033SP	HEAT ROD	2
17	9202-0120SPV2	BARBED STUD	1
18 (A)	9202-0004-1	HEATER BAR STUD	0
19 (A)	3/8-16X1FB	FLANGE BOLT	0

HEAT TREAT NOTES:

TOLERANCES.....EXCEPT AS NOTED

DECIMAL	FRACTIONAL	ANGULAR
XXX ±.005	±1/32"	±1/2°
.XX ±.010		

BREAK ALL SHARP EDGES
SURFACE FINISH ✓ 125

DATE 01-10-19

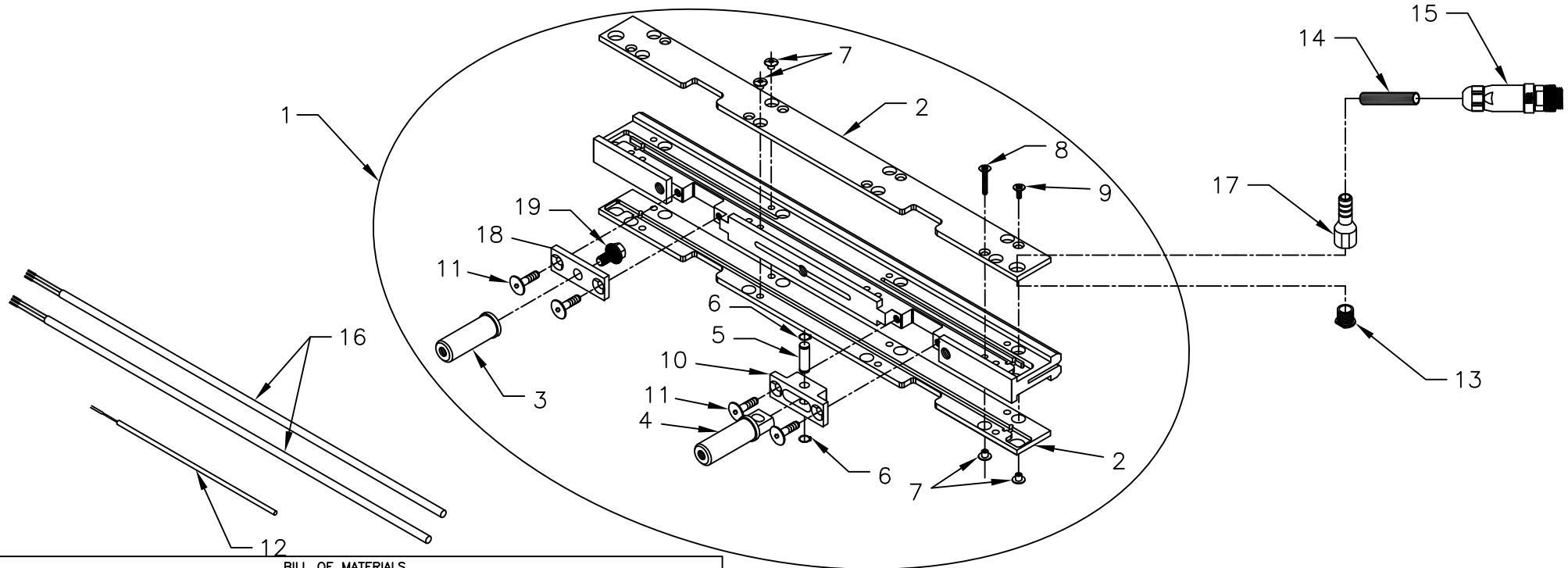
DRAWN BY D. WHITMIRE



PH. 479-521-0525
FAX 479-521-2448
1501 ARMSTRONG AVE
FAYETTEVILLE, AR 72701

TITLE	HEATER BAR ASSEMBLY	REV.	A
PART NUMBER	A9202-0005PBSPV2EC	SHEET	1 OF 1

REVISION	DESCRIPTION	DATE
A D.W.	9202-0033SP WAS 9202-0033L.	10-14-19
B D.W.	9202-0029S WAS 9202-0021S-2; ADDED ITEMS 18 & 19.	11-30-20



BILL OF MATERIALS

ITEM	PART NUMBER	DESCRIPTION	QTY
1	9202-0006SPV2	HEATER BAR	1
2	9202-0006SP-1	CAP	0
3	(B) 9202-0029S	HEATER BAR STUD	0
4	9202-0021S	HEATER BAR STUD	0
5	9202-0102	PIN	0
6	5/16EXT	SNAP RING	0
7	9500-120	BARREL NUT	0
8	8-32X7/8PFH	PHILLIPS FLAT HEAD	0
9	8-32X5/16PFH	PHILLIPS FLAT HEAD	0
10	9202-0004	HEATER BAR INSERT	0
11	1/4-20X5/8FH	FLAT HEAD BOLT	0
12	9200-0073	PROBE	1
13	9202-0120SP-1	STUD	1
14	9500-104	WIRE SLEEVE	3'
15	9202-0074-4	MALE RECEPTACLE	1
16	(A) 9202-0033SP	HEAT ROD	2
17	9202-0120SPV2	BARBED STUD	1
18	(B) 9202-0004-1	HEATER BAR INSERT	0
19	(B) 3/8-16X1FB	FLANGE BOLT	0

HEAT TREAT NOTES:

TOLERANCES.....EXCEPT AS NOTED

DECIMAL	FRACTIONAL	ANGULAR
XXX ±.005	±1/32"	±1/2'
.XX ±.010		

BREAK ALL SHARP EDGES
SURFACE FINISH ✓ 125

DATE 06-22-18

DRAWN BY D. WHITMIRE



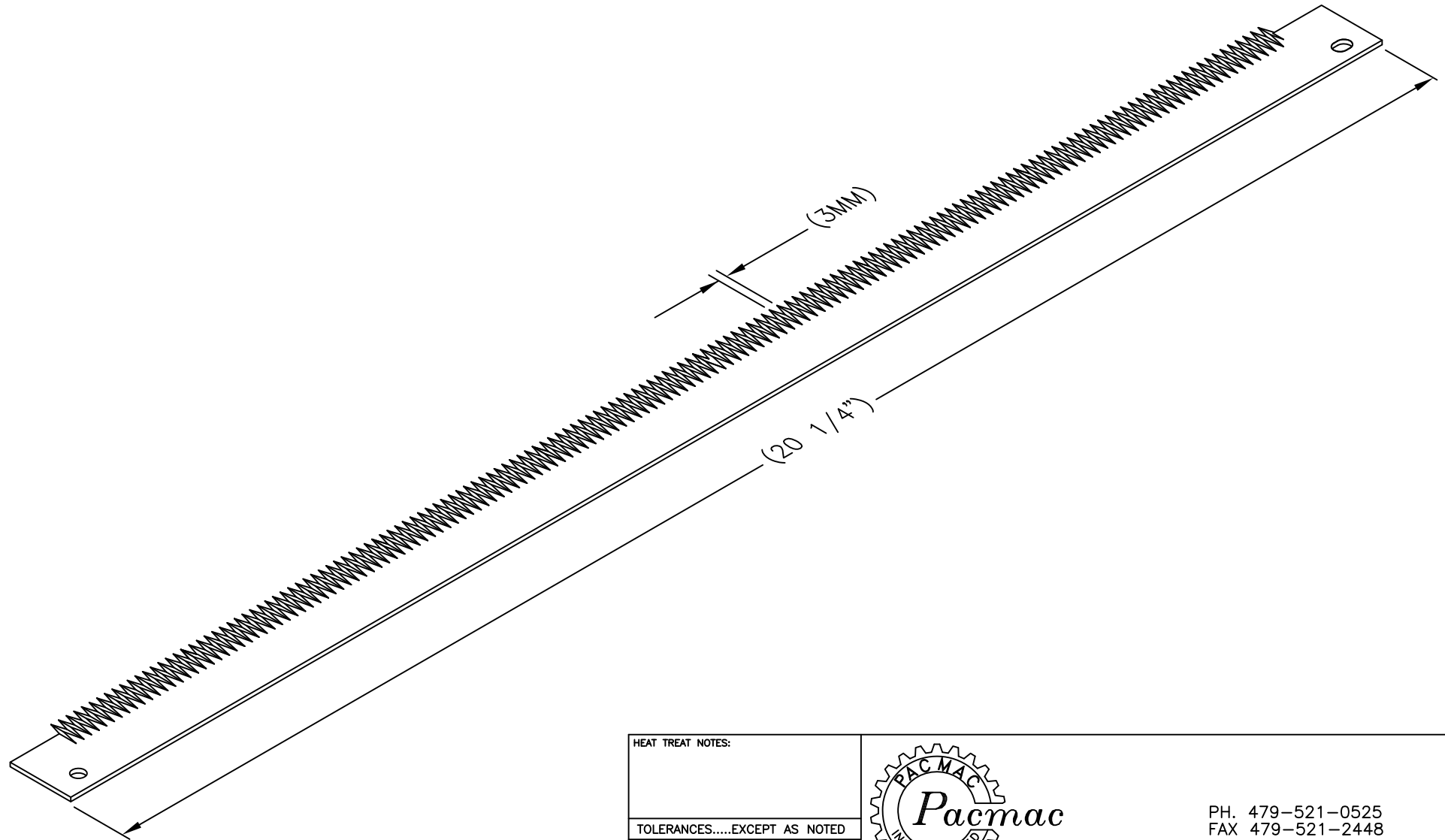
PH. 479-521-0525
FAX 479-521-2448
1501 ARMSTRONG AVE
FAYETTEVILLE, AR 72701

TITLE	HEATER BAR ASSEMBLY	REV.	B
PART NUMBER	A9202-0006SPV2EC	SHEET	1 OF 1

REVISION

DESCRIPTION

DATE



HEAT TREAT NOTES:

TOLERANCES.....EXCEPT AS NOTED

DECIMAL	FRACTIONAL	ANGULAR
.XXX ±.005	±1/32"	±1/2°
.XX ±.010		

BREAK ALL SHARP EDGES
SURFACE FINISH ✓ 125

CHKD	DATE
	07-24-14

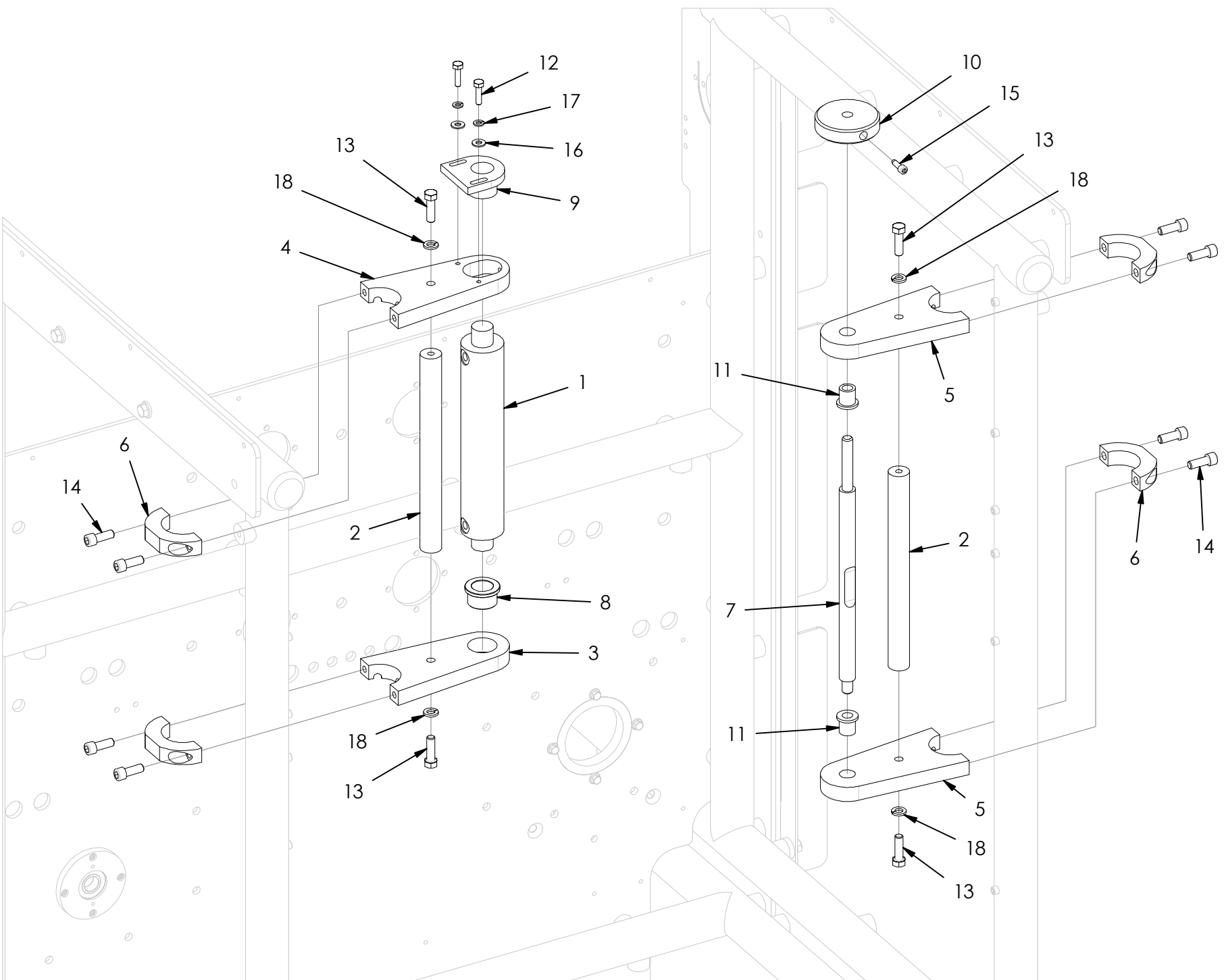
DRAWN BY D. WHITMIRE



PH. 479-521-0525
 FAX 479-521-2448
 1501 ARMSTRONG AVE
 FAYETTEVILLE, AR 72701

TITLE	KNIFE BLADE	REV.	
PART NUMBER	9202-0009	SHEET	2 of 2

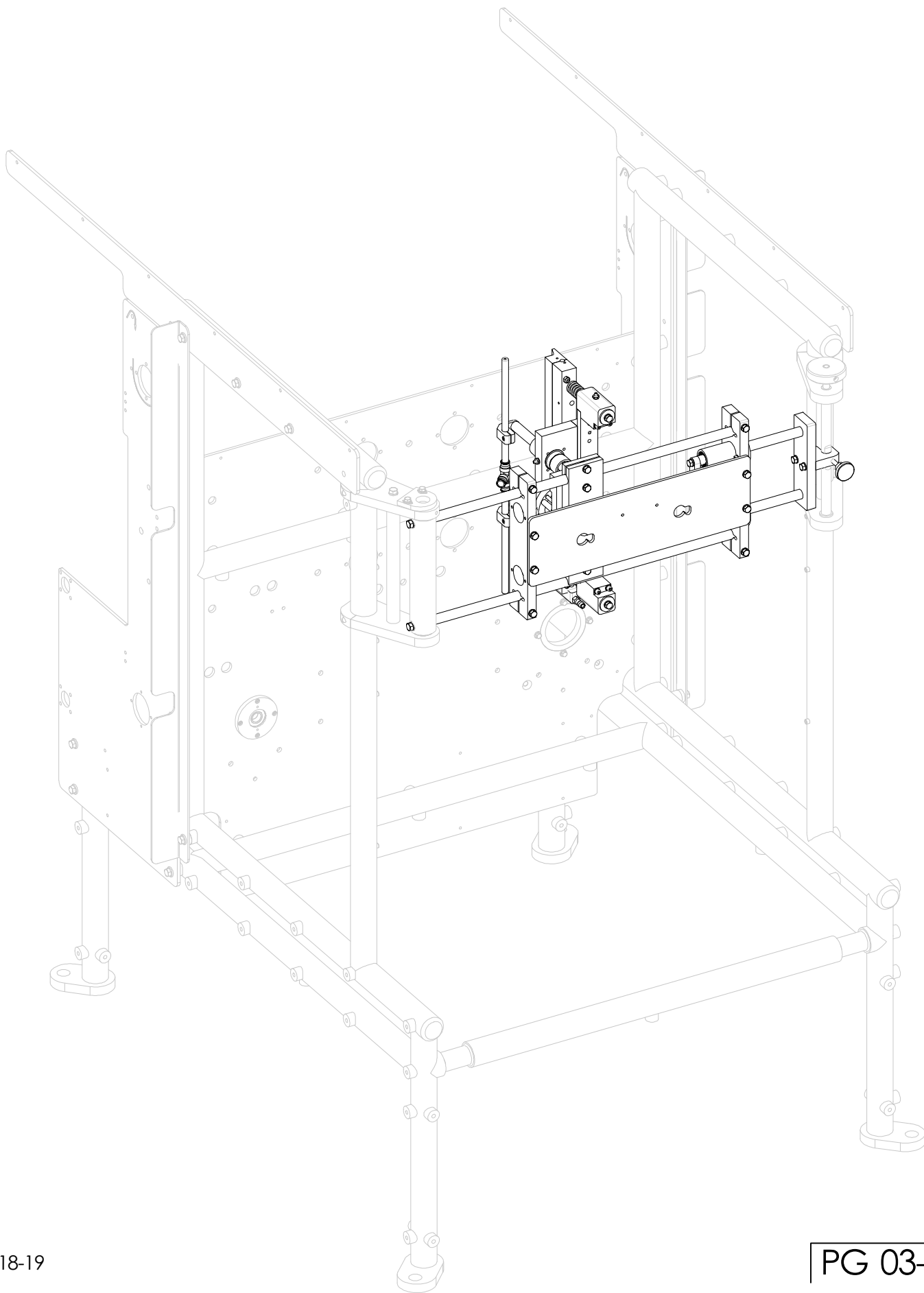
1503MK Mounting Kit



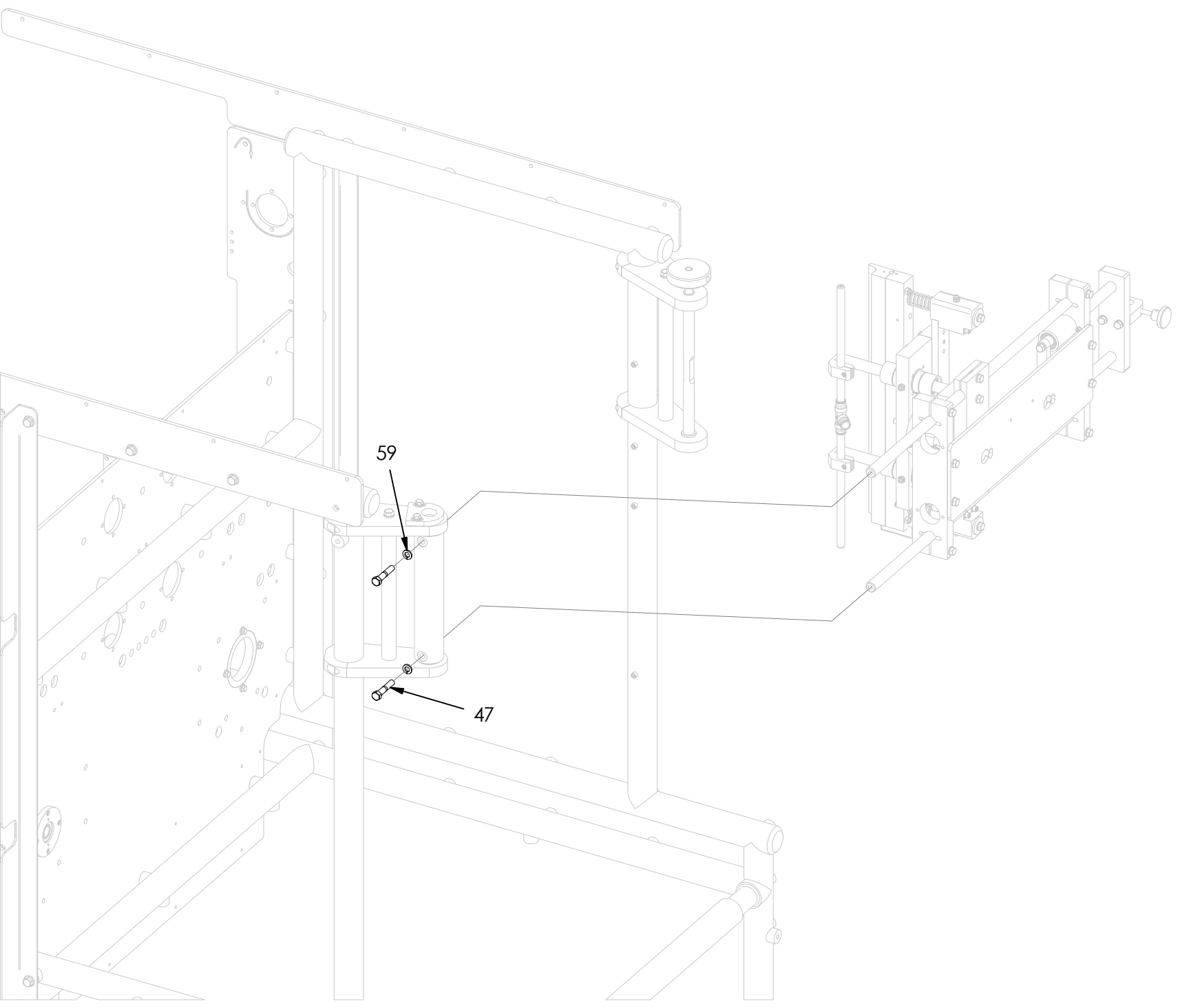
1503MK Mounting Kit

ITEM	PART NUMBER	DESCRIPTION	QTY
1	1503-0009	Support Column	1
2	1503-0081	Shaft	2
3	1503-0101	Pivot Mount	1
4	1503-0101A	Pivot Mount	1
5	1503-0102	Pivot Mount	2
6	1503-0105	Cap	4
7	1503-0106	Lock shaft	1
8	9200-0052	Bushing	1
9	9203-0026	Adj. Pivot Bushing	1
10	9214-0003	Handwheel	1
11	9214-0005	Bushing	2
12	1/4-20X1HH	Hex Head Bolt	2
13	3/8-16X1 1/4HH	Hex Head Bolt	4
14	3/8-16X1SH	Socket Head Bolt	8
15	1/4-20X3/4SHDP	Socket Head Dogpoint Bolt	1
16	1/4FW	Flat Washer	2
17	1/4LW	Lock Washer	2
18	3/8LW	Lock Washer	4

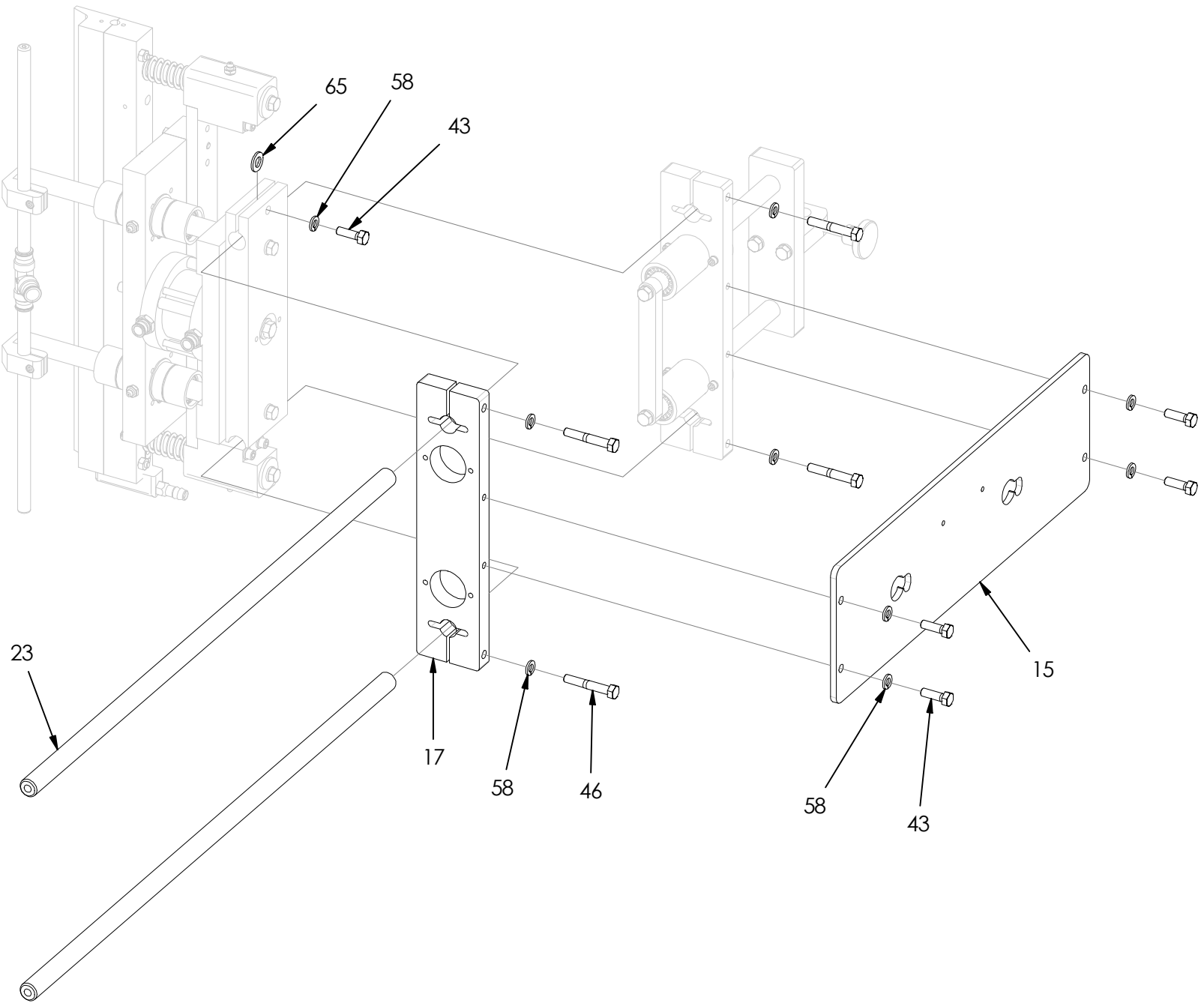
1503PB Vertical Seal Assembly



1503PB Vertical Seal Assembly

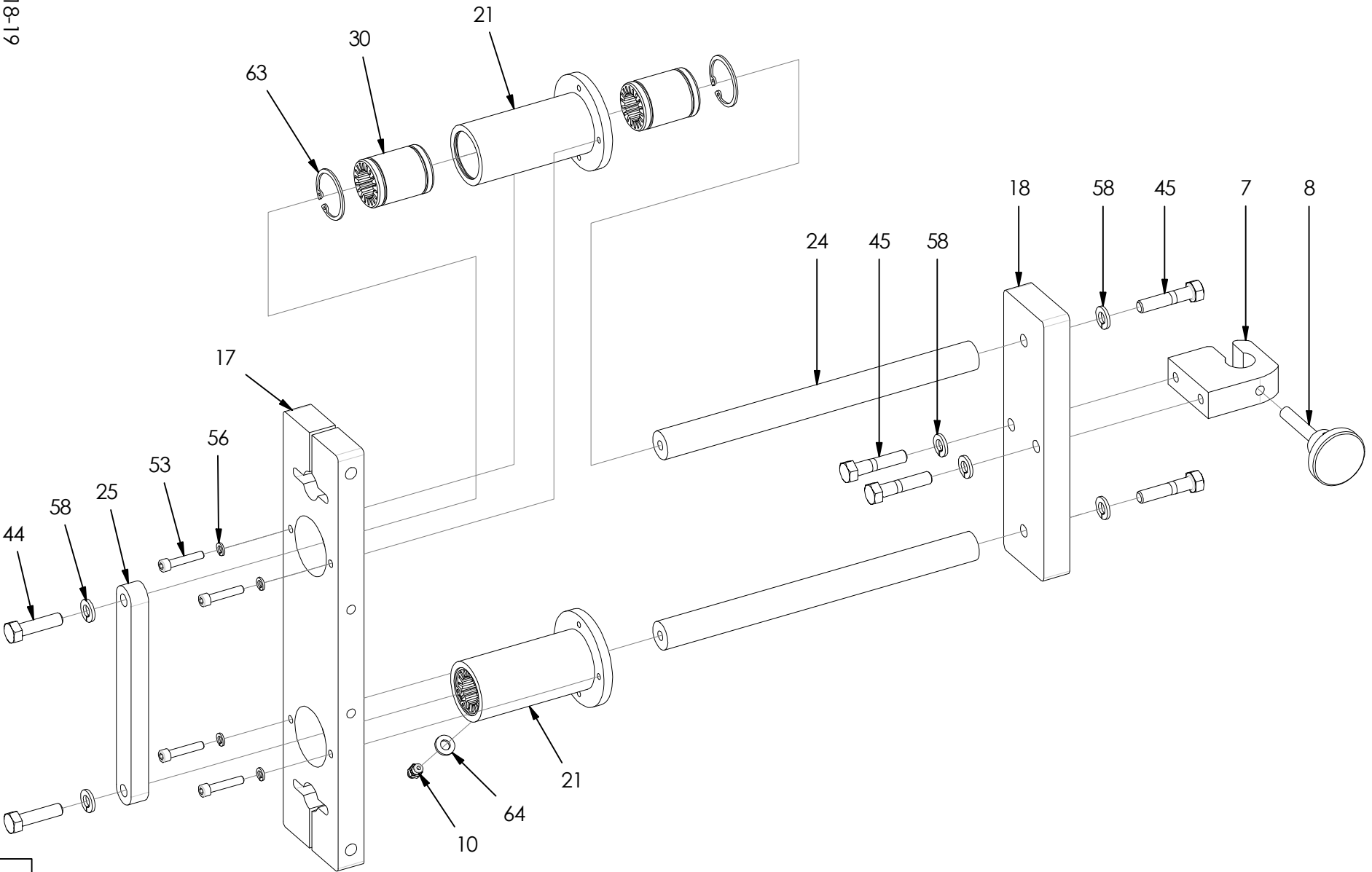


1503PB Vertical Seal Assembly



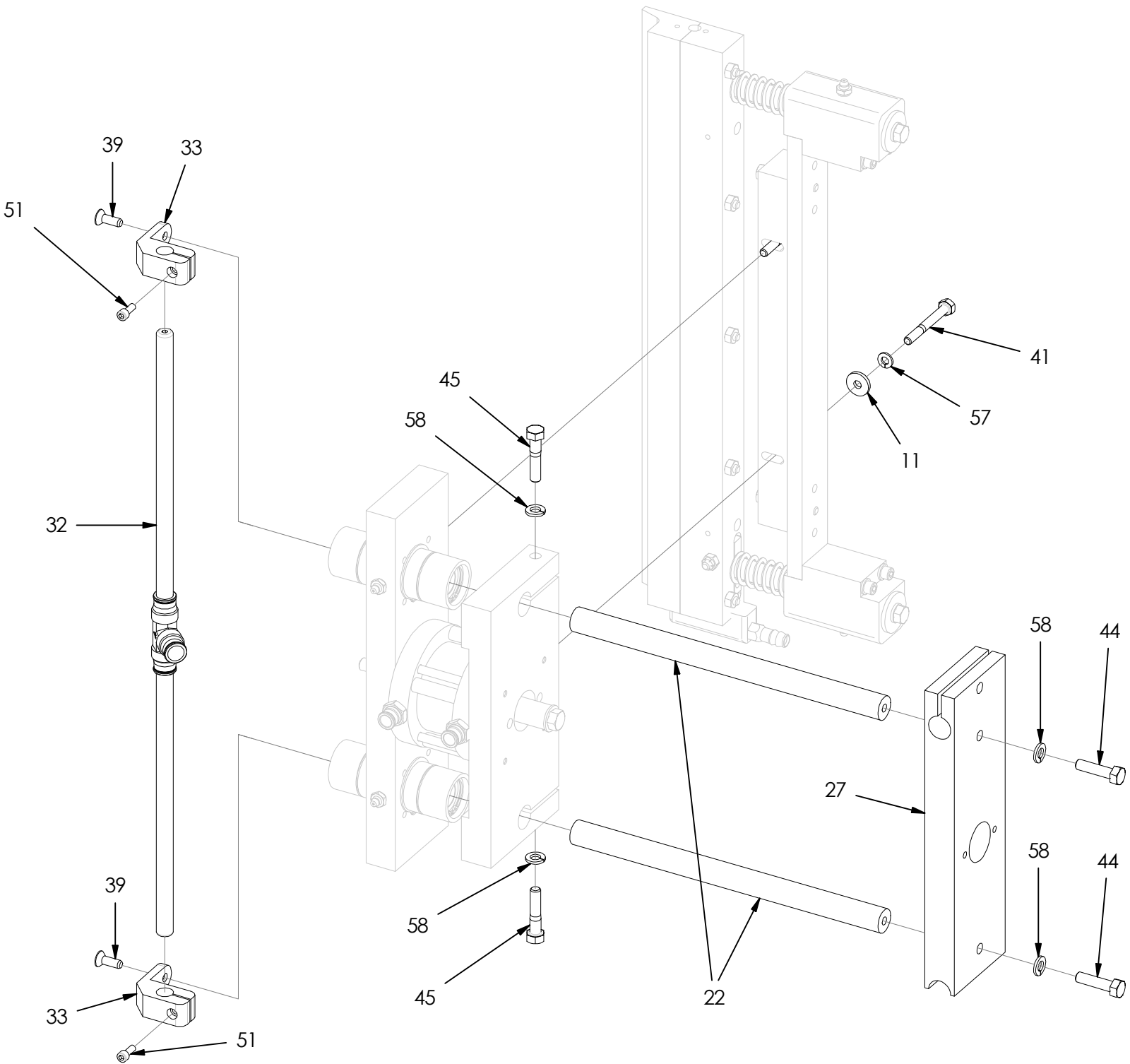
1503PB Vertical Seal Assembly

10-18-19



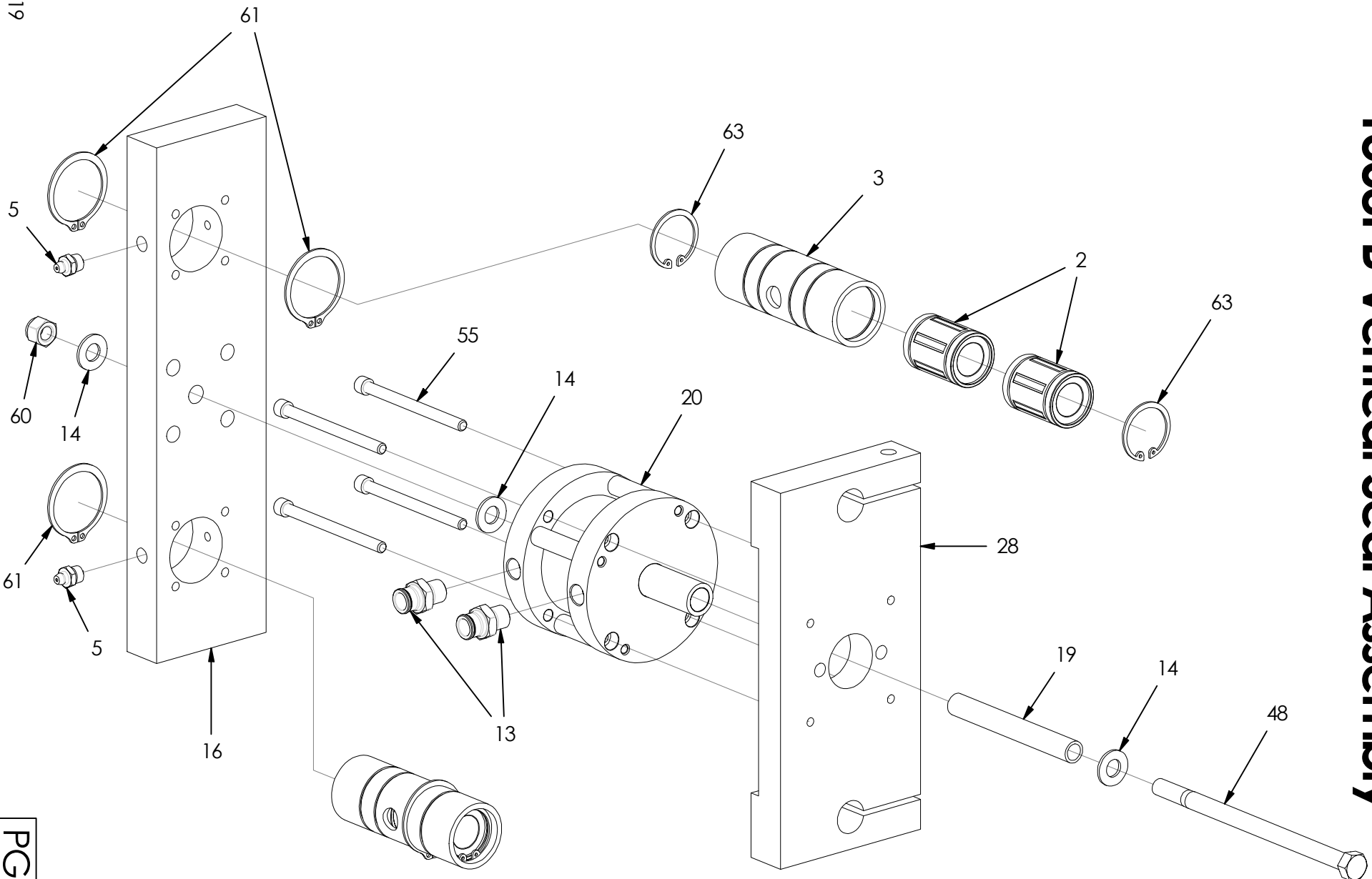
PG 03-11

1503PB Vertical Seal Assembly



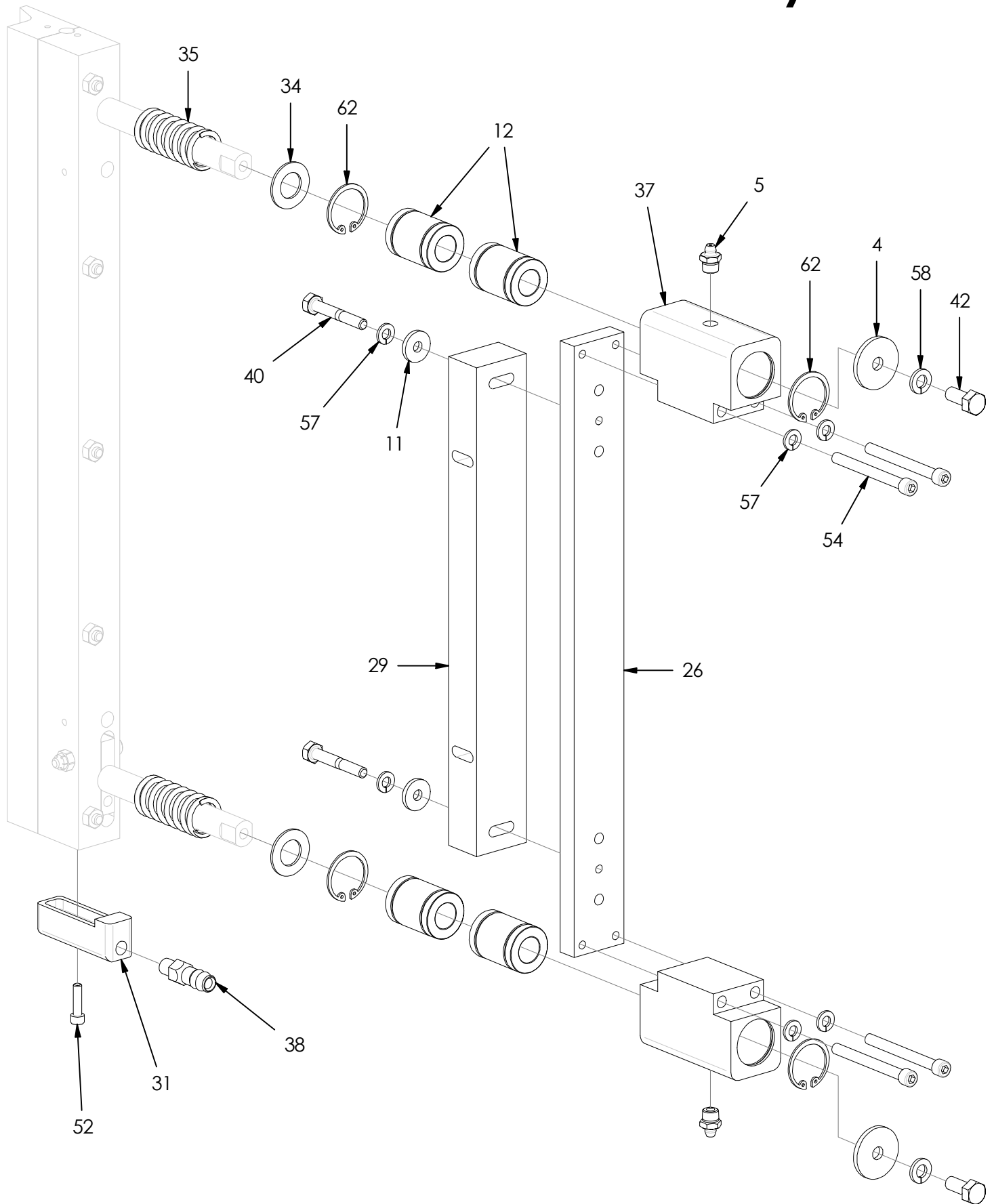
1503PB Vertical Seal Assembly

10-18-19

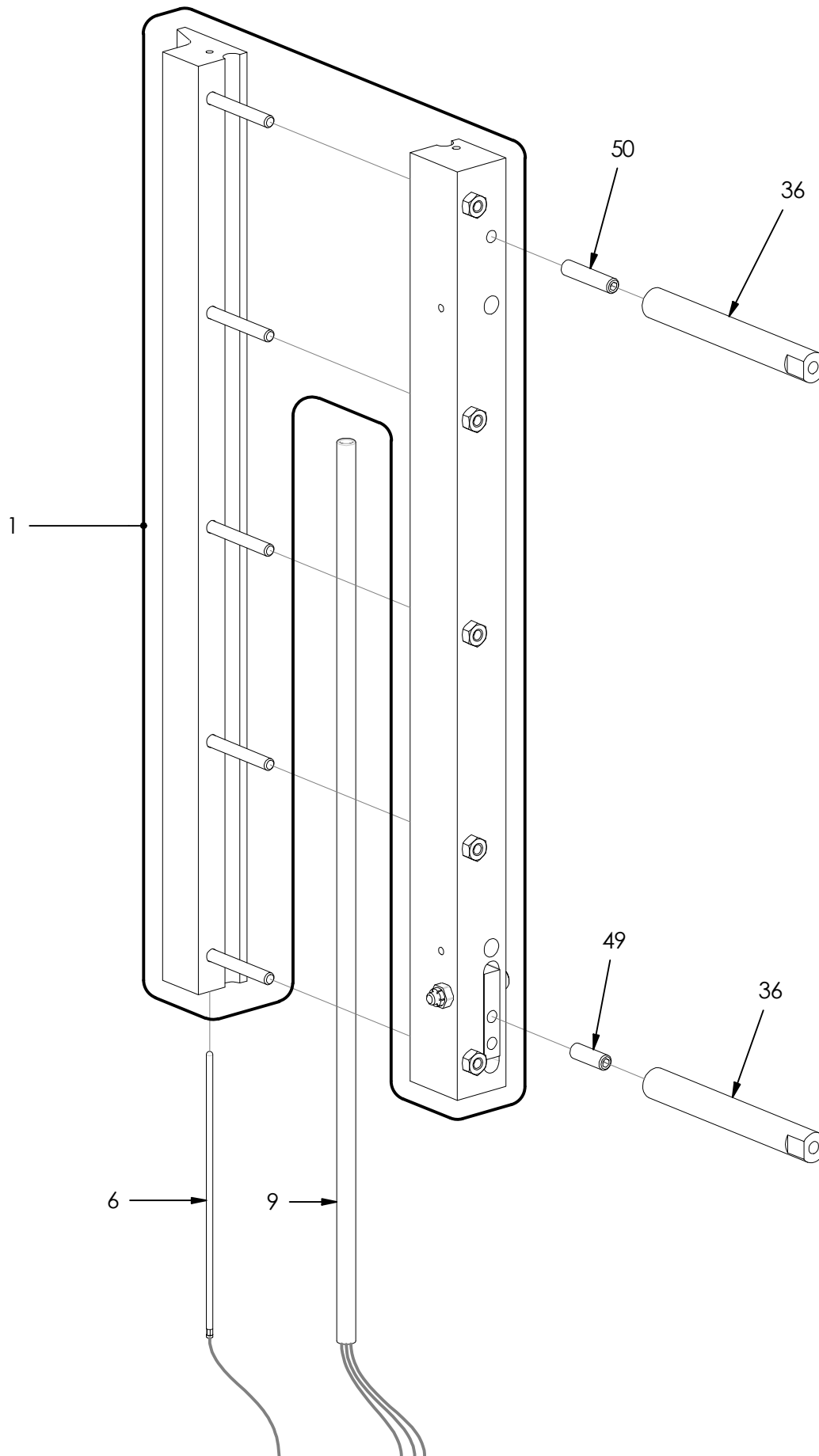


PG 03-13

1503PB Vertical Seal Assembly



1503PB Vertical Seal Assembly



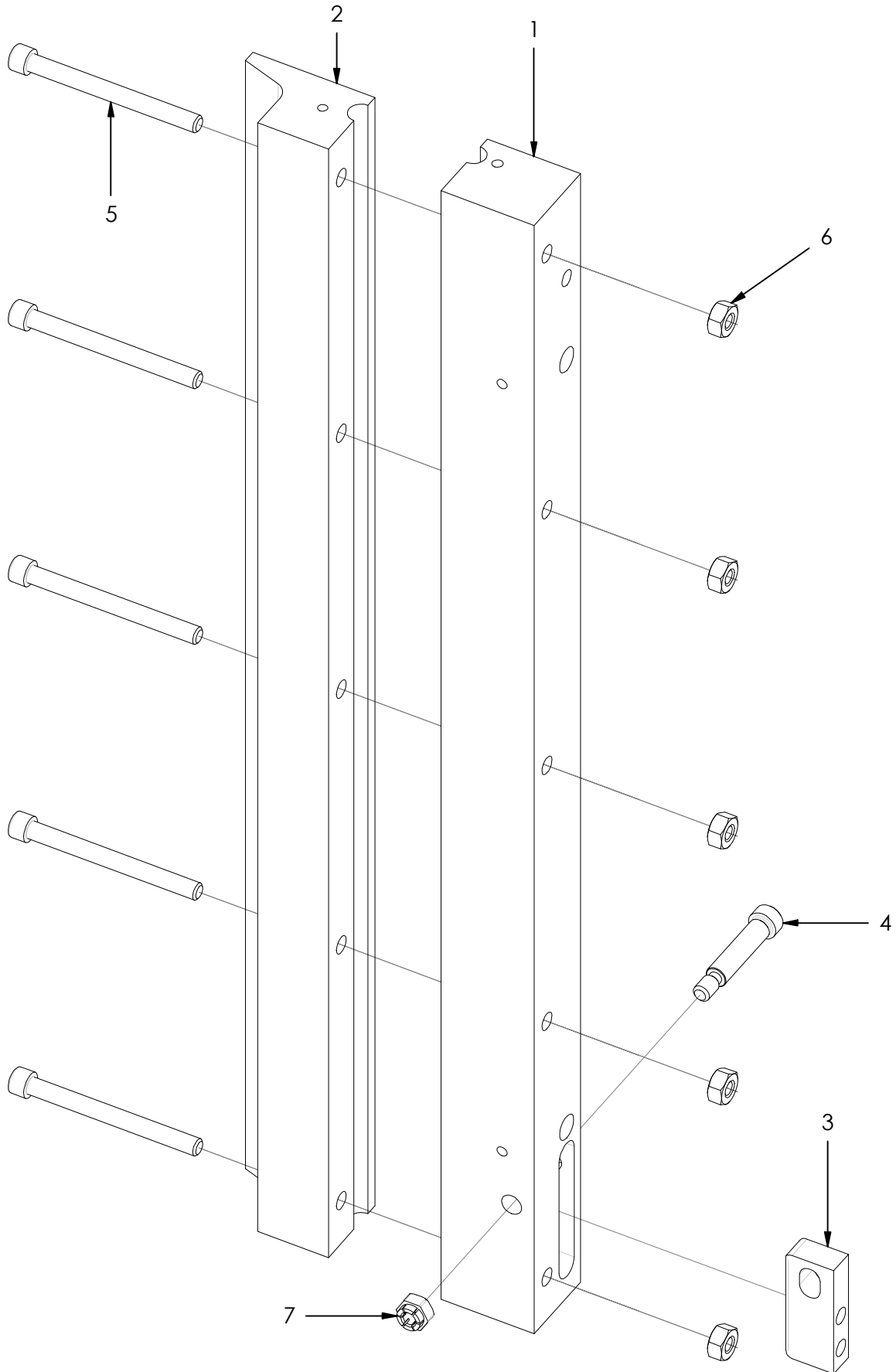
1503PB Vertical Seal Assembly

ITEM	PART NUMBER	DESCRIPTION	QTY
1	9203-0012SP	Heater Bar Assembly	1
2	9200-0059	Linear Bearing	4
3	9200-0061	Bearing Sleeve	2
4	9200-0062	Flat Washer	2
5	9200-0069	Grease Zerk	4
6	9200-0073	Temperature Probe	1
7	9203-0011	Lock Block	1
8	9203-0011 -1	Knob	1
9	9203-0014	Heat Rod	1
10	9203-0063	Grease Zerk	2
11	9208-0016	Washer	4
12	9209-0010	Linear Bearing	4
13	9216-0015	Tubing Connector	2
14	9500-127	Washer	3
15	9503-0001SS -3	Mounting Plate	1
16	9503-0002	Slide Block	1
17	9503-0003	Shaft Support	2
18	9503-0004P	Shaft Support	1
19	9503-0005 -1	Sleeve	1
20	9503-0005S	Air Cylinder	1
21	9503-0006	Mount	2
22	9503-0007SS	Linear Shaft	2
23	9503-0010SS	Shaft	2
24	9503-0017	Stainless Shaft	2
25	9503-0018	Strap	1
26	9503-0021NS	Strap	1
27	9503-0034	Support	1
28	9503-0036	Support	1
29	9503-0039	Support	1
30	9503-0058	Bushing	4
31	9503-0064 -4	Wire Channel	1
32	9503-0075	Cooling Tube	1
33	9503-0075 -3	Tube Bracket	2
34	9503-0084	Washer	2
35	9503-0089NS	Spring	2
36	9503-0090SL	Heater Shaft	2
37	9503-0091NS	Bearing Block	2
38	9503-0110SPV2	Barbed Stud	1
39	1/4-20X3/4FH	Flat Head Bolt	2

1503PB Vertical Seal Assembly

ITEM	PART NUMBER	DESCRIPTION	QTY
40	1/4-20X1 3/4HH	Hex Head Bolt	2
41	1/4-20X2 1/4HH	Hex Head Bolt	2
42	5/16-18X3/4HH	Hex Head Bolt	2
43	5/16-18X1HH	Hex Head Bolt	5
44	5/16-18X1 1/4HH	Hex Head Bolt	4
45	5/16-18X1 1/2HH	Hex Head Bolt	6
46	5/16-18X2HH	Hex Head Bolt	4
47	3/8-16X2HH	Hex Head Bolt	2
48	3/8-16X6.5HH	Hex Head Bolt	1
49	5/16-18X1SS	Set Screw	1
50	5/16-18X1 1/2SS	Set Screw	1
51	10-32X1/2SH	Socket Head Bolt	2
52	10-32X3/4SH	Socket Head Bolt	1
53	10-32X1SH	Socket Head Bolt	4
54	1/4-20X2 1/2SH	Socket Head Bolt	4
55	1/4-20X3 1/4SH	Socket Head Bolt	4
56	#10LW	Lock Washer	4
57	1/4LW	Lock Washer	8
58	5/16LW	Lock Washer	21
59	3/8LW	Lock Washer	2
60	3/8-16LN	Lock Nut	1
61	1 1/2EXT	Snap Ring	4
62	1 1/8INT	Snap Ring	4
63	1 1/4INT	Snap Ring	8
64	M6FW	Flat Washer	2
65	M10FW	Flat Washer	1

9203-0012SP Heater Bar Assembly

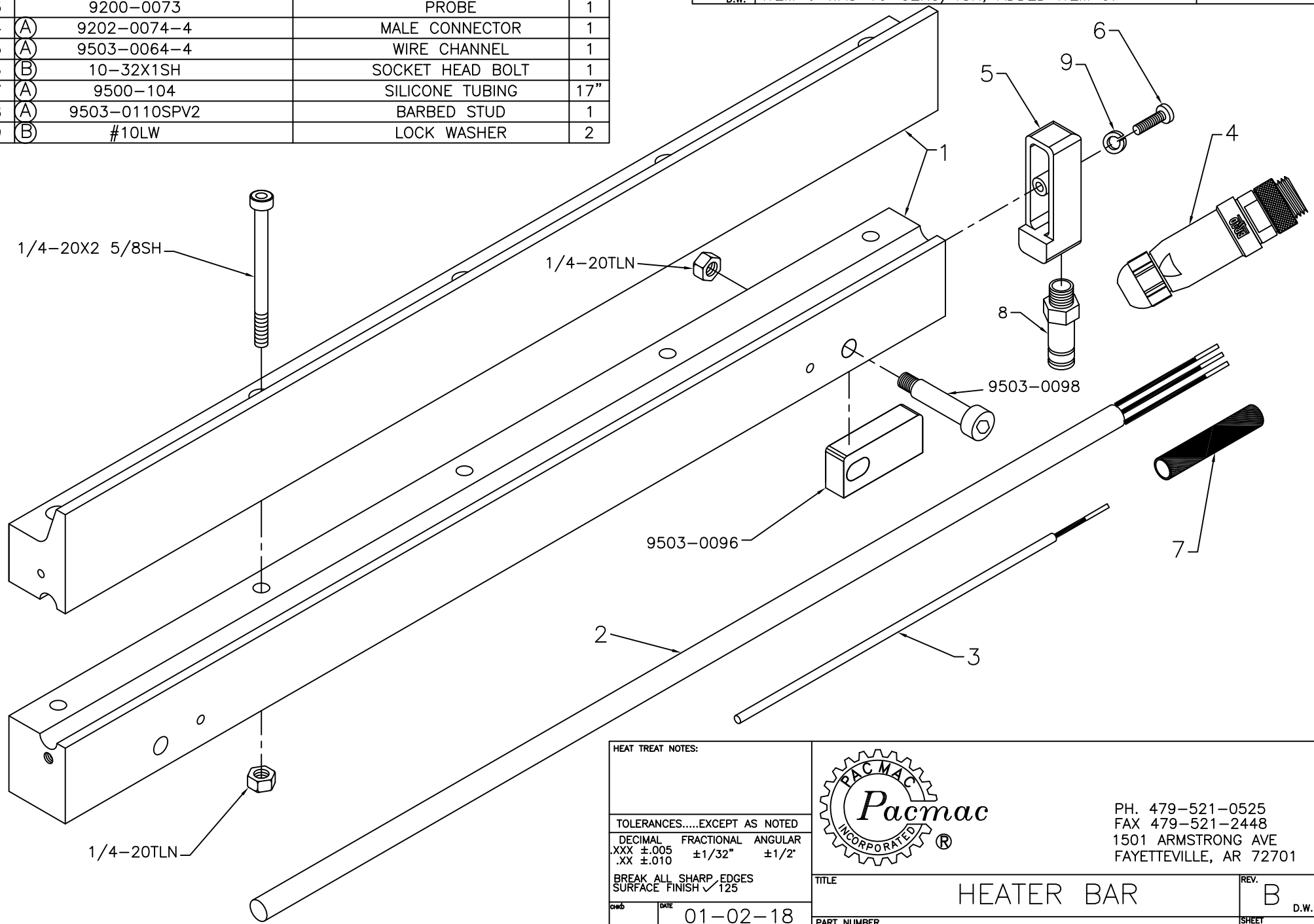


9203-0012SP Heater Bar Assembly

ITEM	PART NUMBER	DESCRIPTION	QTY
1	9203-0012SP -1	Heater Bar Base	1
2	9203-0012SP -2	Heater Bar Tip	1
3	9503-0096	Insert	1
4	9503-0098	Shoulder Bolt	1
5	1/4-20X2 5/8SH	Socket Head Bolt	5
6	1/4-20HN	Hex Nut	5
7	1/4-20LN	Lock Nut	1

BILL OF MATERIALS			
ITEM	PART NUMBER	DESCRIPTION	QTY
1	9203-0012SP	HEATER BAR	1
2	9203-0014	HEAT ROD	1
3	9200-0073	PROBE	1
4	(A) 9202-0074-4	MALE CONNECTOR	1
5	(A) 9503-0064-4	WIRE CHANNEL	1
6	(B) 10-32X1SH	SOCKET HEAD BOLT	1
7	(A) 9500-104	SILICONE TUBING	17"
8	(A) 9503-0110SPV2	BARBED STUD	1
9	(B) #10LW	LOCK WASHER	2

REVISION	DESCRIPTION	DATE
A D.W.	ADDED ITEM 8; ITEM 5 WAS 9503-0064; ITEM 7 WAS #10 LW; ITEM 4 WAS 9200-0016.	06-11-15
B D.W.	ITEM 6 WAS 10-32X3/4SH; ADDED ITEM 9.	05-03-19



HEAT TREAT NOTES:

TOLERANCES.....EXCEPT AS NOTED

DECIMAL	FRACTIONAL	ANGULAR
.XXX ±.005	±1/32"	±1/2'
.XX ±.010		

BREAK ALL SHARP EDGES
SURFACE FINISH ✓ 125

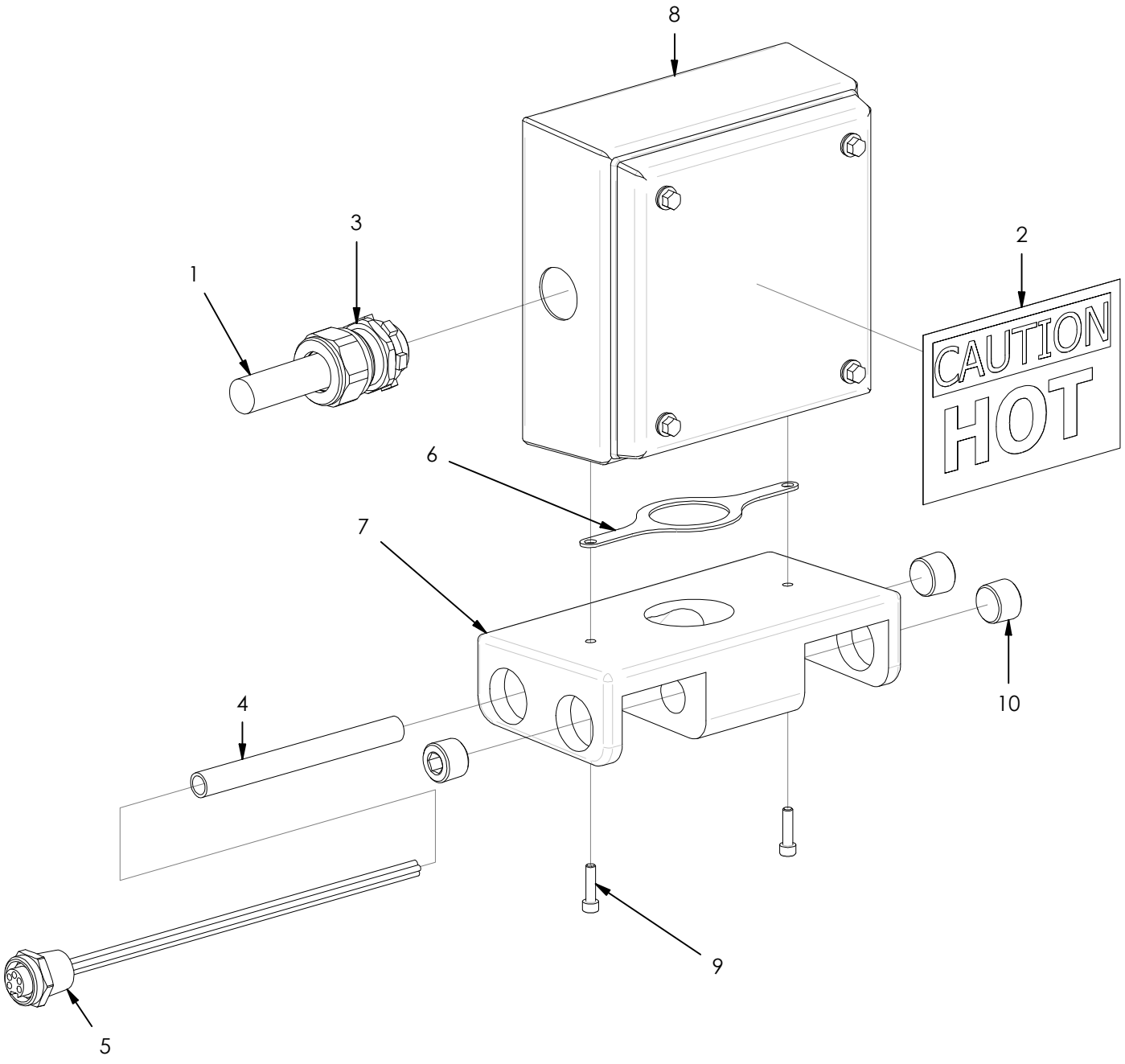
CHKD DATE 01-02-18
DRAWN BY D. WHITMIRE



PH. 479-521-0525
FAX 479-521-2448
1501 ARMSTRONG AVE
FAYETTEVILLE, AR 72701

TITLE	HEATER BAR	REV.	B
PART NUMBER	A9203-0012SP	D.W.	
		SHEET	1 of 1

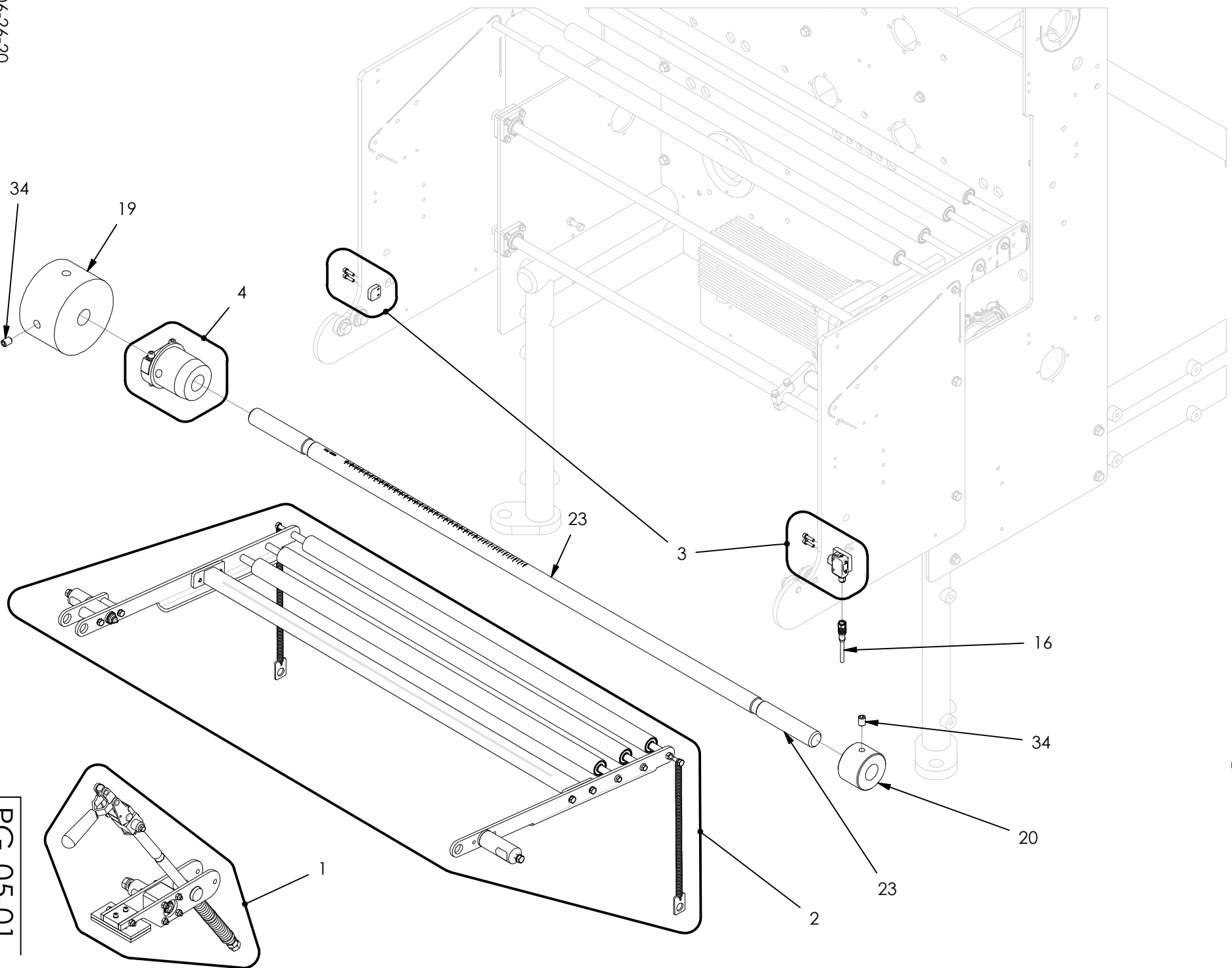
A9503-0047SSULR -PB Junction Box Assembly



A9503-0047SSULR -PB Junction Box Assembly

ITEM	PART NUMBER	DESCRIPTION	QTY
1	1503-0077V	Vert. Heater Cable	0
2	9203-0048 -L	Caution Hot Label	1
3	9216-0048SS	SS Cord Grip	1
4	9500-104	Tubing	5"
5	9500-134	Female Receptical	1
6	9503-0047SSUL - 8	Gasket	1
7	9503-0047SSUL -7	Wireway	1
8	9503-0047SSULR	Junction Box	1
9	10-32X3/4SH	Socket Head Bolt	2
10		1/2" NPT St Stl Plug, Pipe	3

1505V2 Film Unwind Assembly

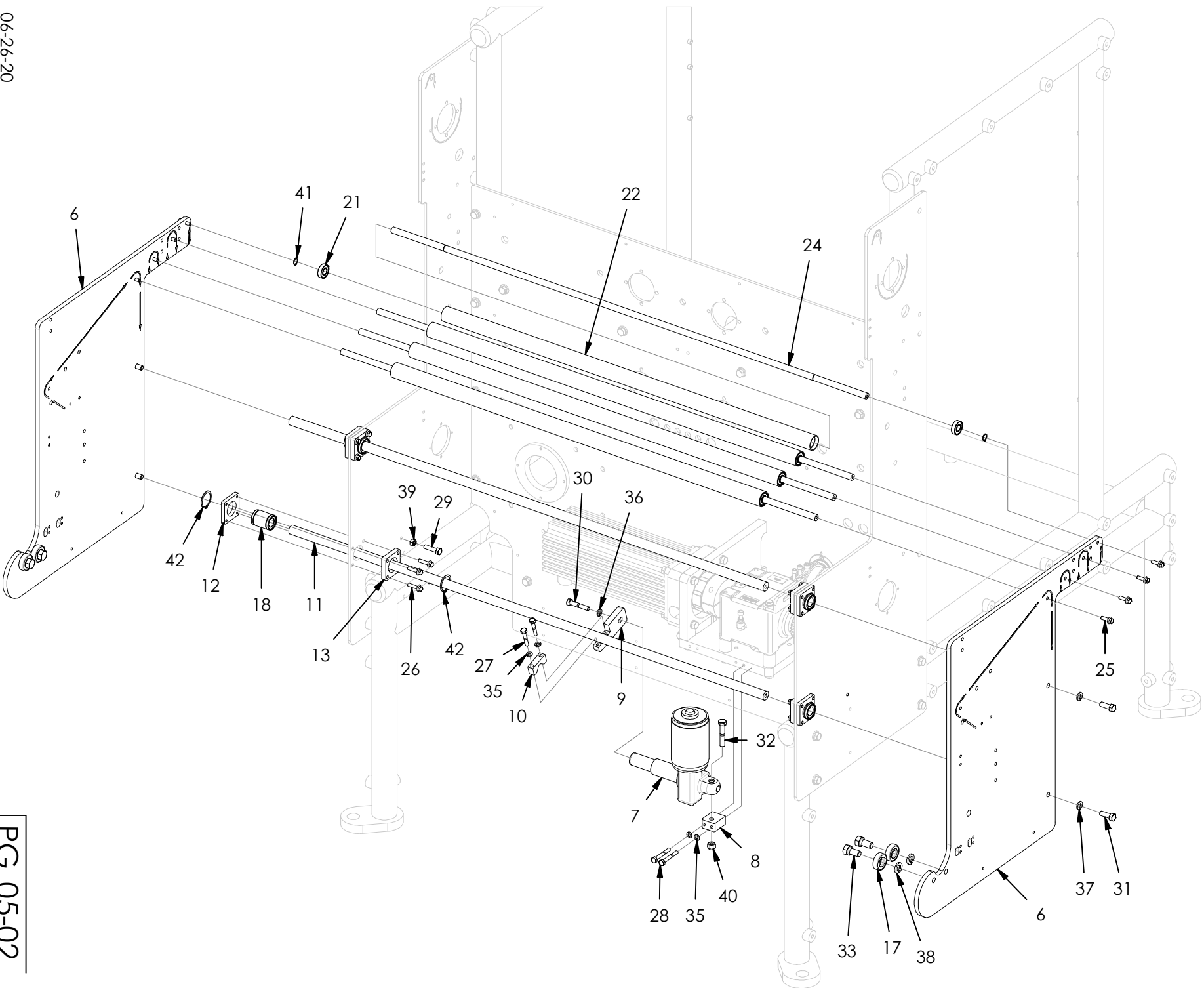


06-26-20

PG 05-01

1505V2 Film Unwind Assembly

06-26-20

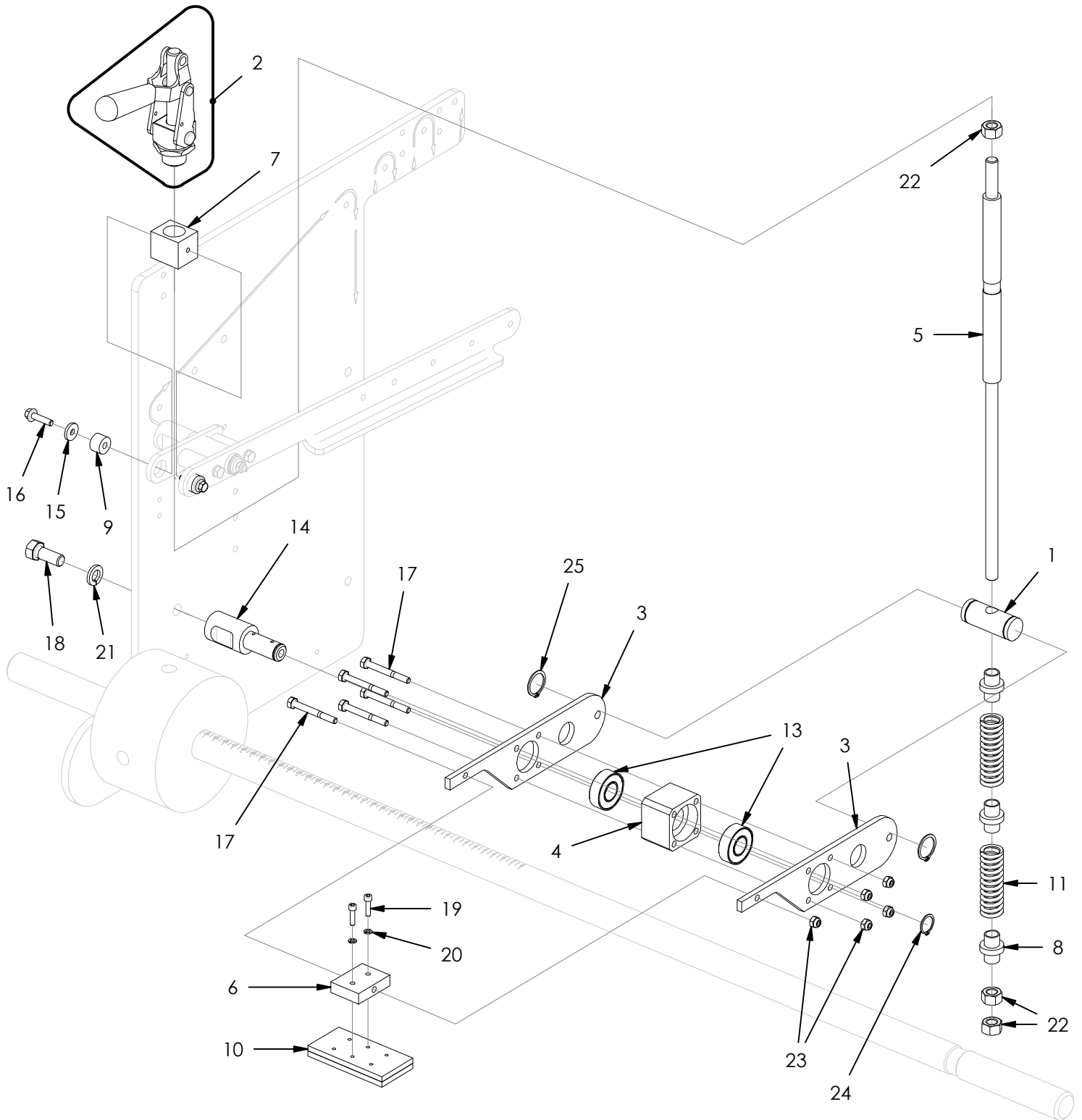


PG 05-02

1505V2 Film Unwind Assembly

ITEM	PART NUMBER	DESCRIPTION	QTY
1	1505-0310HD	Dual Brake Sub-Assembly	1
2	1505-A001V2	Dancer Bar Sub-Assembly	1
3	1519L	Low Film Assembly	1
4	9505-0012	Core Chuck Assembly	1
6	1505-0001V2	Side Frame	2
7	1505-0003	24VDC Linear Actuator	1
8	1505-0006	Motor Mount	1
9	1505-0007	Shaft Clamp	1
10	1505-0007C	Cap	1
11	1505-0030	Shaft	2
12	1505-0104	Bearing Block	4
13	1505-0105	Bearing Block	4
16	1518-A222	Low Film Sensor Cable	0
17	9200-0053	Bearing	4
18	9200-0059SS	Linear Bearing	4
19	9205-0011PB	Brake Drum	1
20	9205-0013	Hub	1
21	9500-25	Bearing	8
22	9500-65	Roller	4
23	9505-0010	Film Roll Shaft	1
24	9506-0009	Shaft	4
25	1/4-20X3/4FB	Flange Bolt	8
26	1/4-20X1FB	Flange Bolt	16
27	1/4-20X1 1/2HH	Hex Head Bolt	2
28	1/4-20X2HH	Hex Head Bolt	2
29	5/16-18X1 1/4HH	Hex Head Bolt	2
30	5/16-18X1 3/4HH	Hex Head Bolt	1
31	3/8-16X1HH	Hex Head Bolt	4
32	3/8-16X2HH	Hex Head Bolt	1
33	1/2-13X1HH	Hex Head Bolt	4
34	1/2-13X3/4SS	Set Screw	2
35	1/4LW	Lock Washer	4
36	5/16LW	Lock Washer	1
37	3/8LW	Lock Washer	4
38	1/2LW	Lock Washer	4
39	5/16-18HN	Hex Nut	2
40	3/8-16LN	Lock Nut	1
41	1/2EXT	Snap Ring	8
42	1 1/4EXT	Snap Ring	8

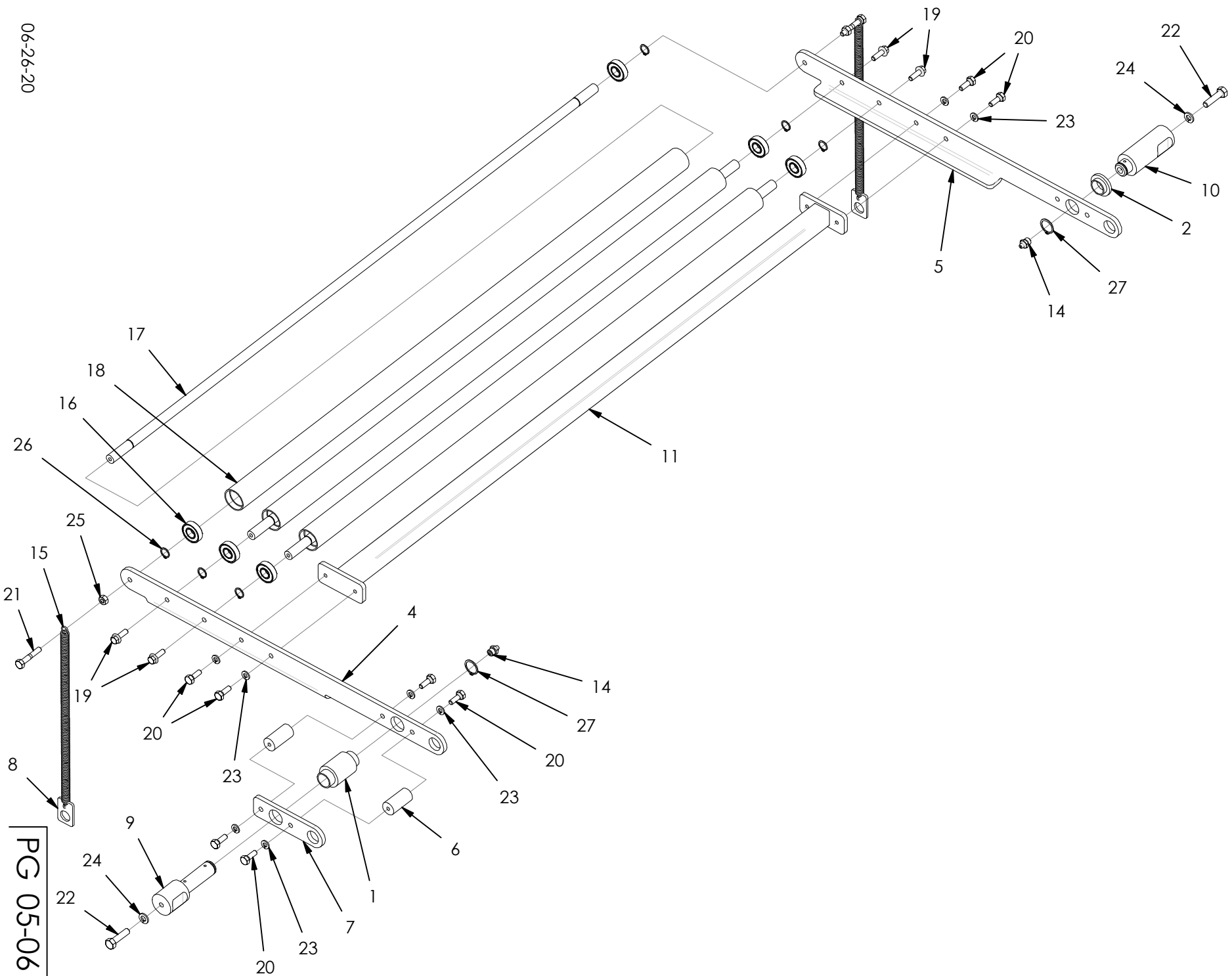
1505-0310HD Brake Sub-Assembly



1505-0310HD Brake Sub-Assembly

ITEM	PART NUMBER	DESCRIPTION	QTY
1	1500-0019	Pivot Pin	1
2	1500-0051HD	Toggle Clamp	1
3	1505-0015	Plate	2
4	1505-0016	Bearing Housing	1
5	1505-0021	Adjusting Rod	1
6	1505-0040	Plate	1
7	9200-0020 -2	Pivot Block	1
8	9200-0023 -3	Spring Guide	3
9	9200-0033 -2	Bushing	2
10	9200-0040X30	Brake Pad	1
11	9200-0044SS	Spring	2
12	9200-0069	Grease Zerk	1
13	9202-0043	Bearing	2
14	9205-0020PB	Pivot Stud	1
15	9208-0016	Washer	2
16	1/4-20X1FB	Flange Bolt	2
17	1/4-20X2 1/4HH	Hex Head Bolt	5
18	1/2-13X1 1/4HH	Hex Head Bolt	1
19	10-32X3/4SH	Socket Head Bolt	2
20	#10LW	Lock Washer	2
21	1/2LW	Lock Washer	1
22	1/2-13HN	Hex Nut	3
23	1/4-20LN	Lock Nut	5
24	3/4EXT	Snap Ring	1
25	25MM EXT	Snap Ring	2

1505-A001 V2 Dancer Bar Sub-Assembly



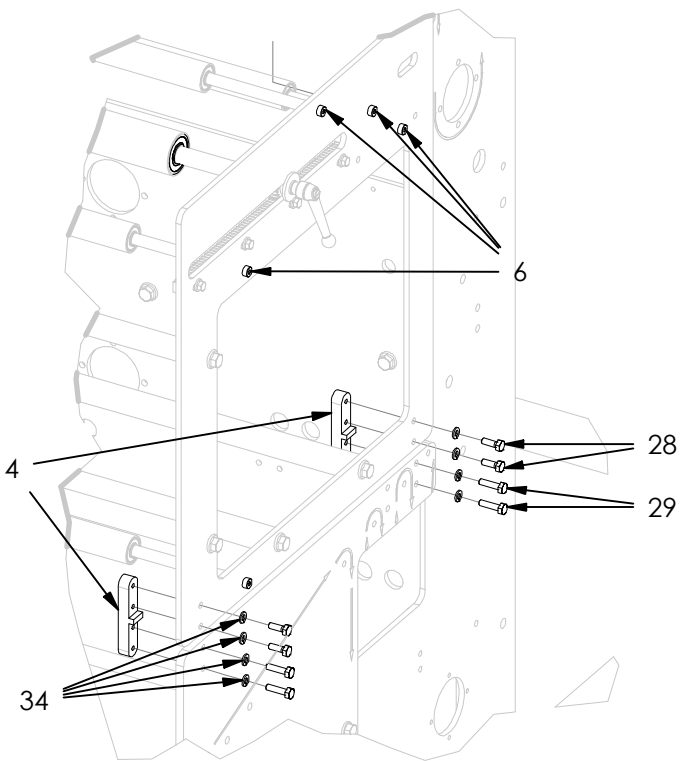
06-26-20

PG 05-06

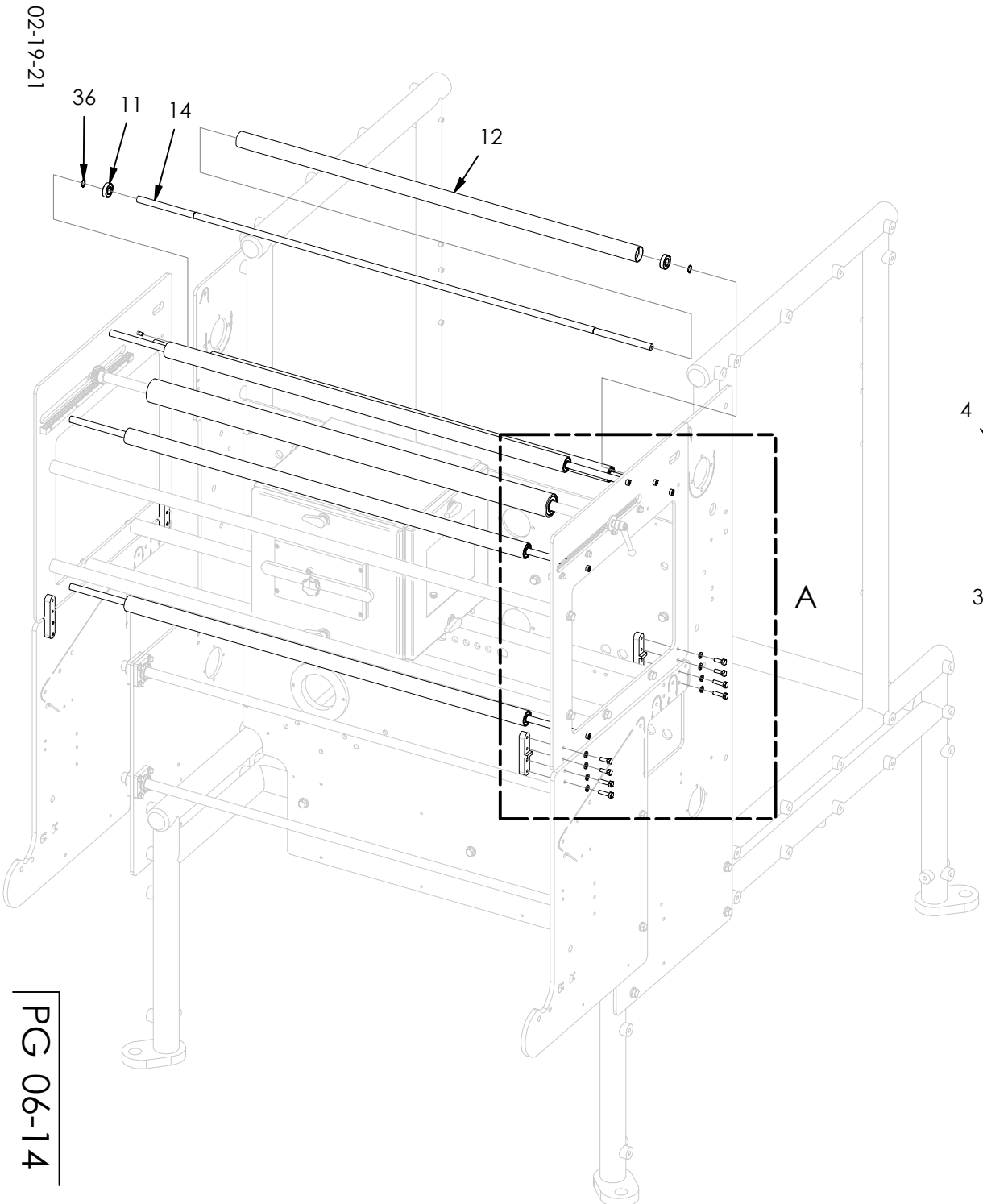
1505-A001V2 Dancer Bar Sub-Assembly

ITEM	PART NUMBER	DESCRIPTION	QTY
1	1500-21P3	Bushing	1
2	1500-22P2	Bushing	1
4	1505-0009L	Roller Frame	1
5	1505-0009R	Roller Frame	1
6	1505-0014 -1	Spacer	2
7	1505-0014V2	Pivot Block	1
8	1505-0018	Tension Adjuster	2
9	1505-0101	Standoff	1
10	1505-0102	Standoff	1
11	1505-0108	Tie Bar	1
14	9200-0069	Grease Zerk	2
15	9205-0040	Spring	2
16	9500-25	Bearing	6
17	9500-57	Shaft	3
18	9500-65	Roller	3
19	1/4-20X3/4FB	Flange Bolt	4
20	1/4-20X3/4HH	Hex Head Bolt	8
21	1/4-20X1 1/2HH	Hex Head Bolt	2
22	5/16-18X1 1/4HH	Hex Head Bolt	2
23	1/4LW	Lock Washer	8
24	5/16LW	Lock Washer	2
25	1/4-20HN	Hex Nut	2
26	1/2EXT	Snap Ring	6
27	3/4EXT	Snap Ring	2

1506M21WD2V2 Markem Printer Bracket Assembly



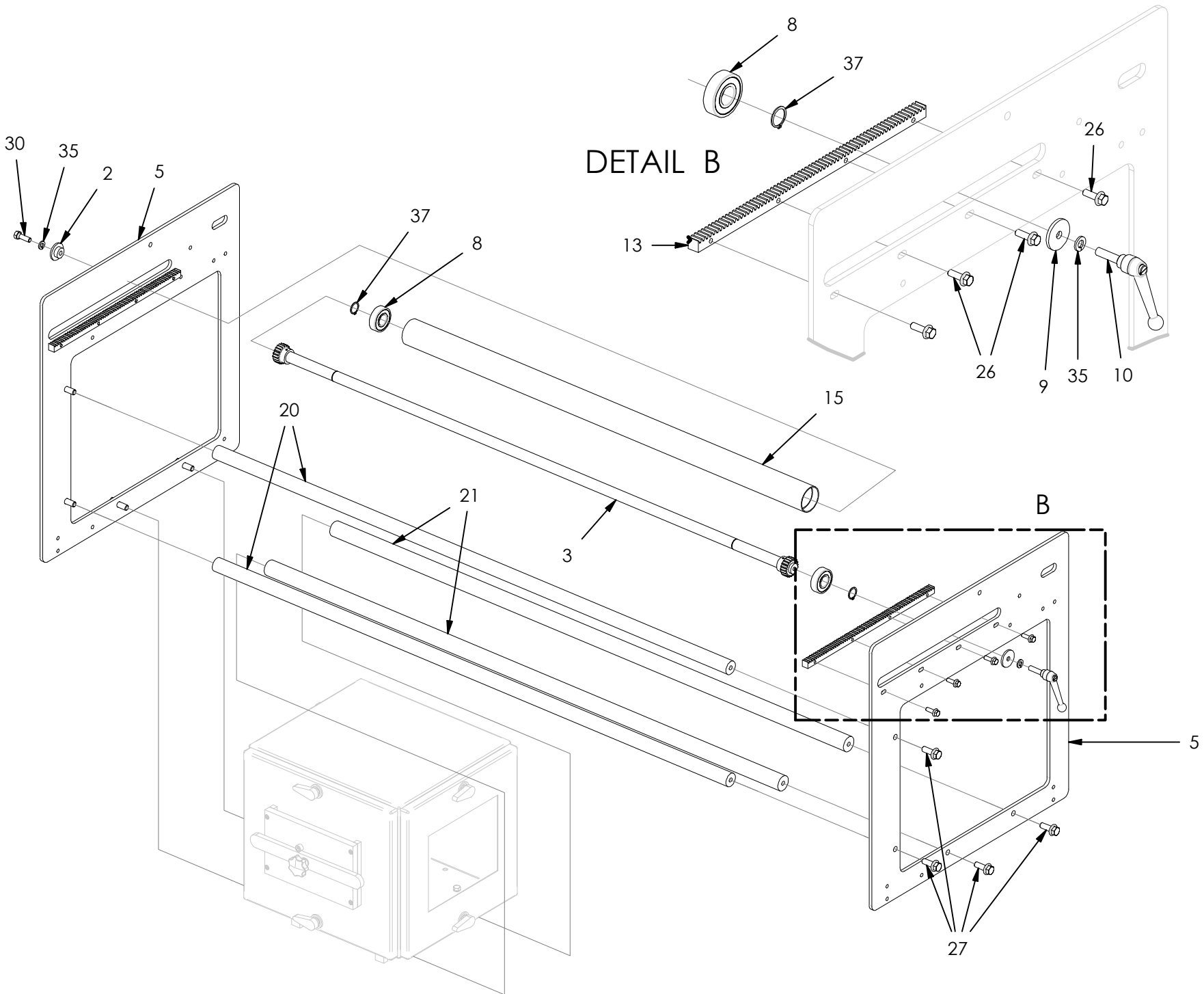
DETAIL A



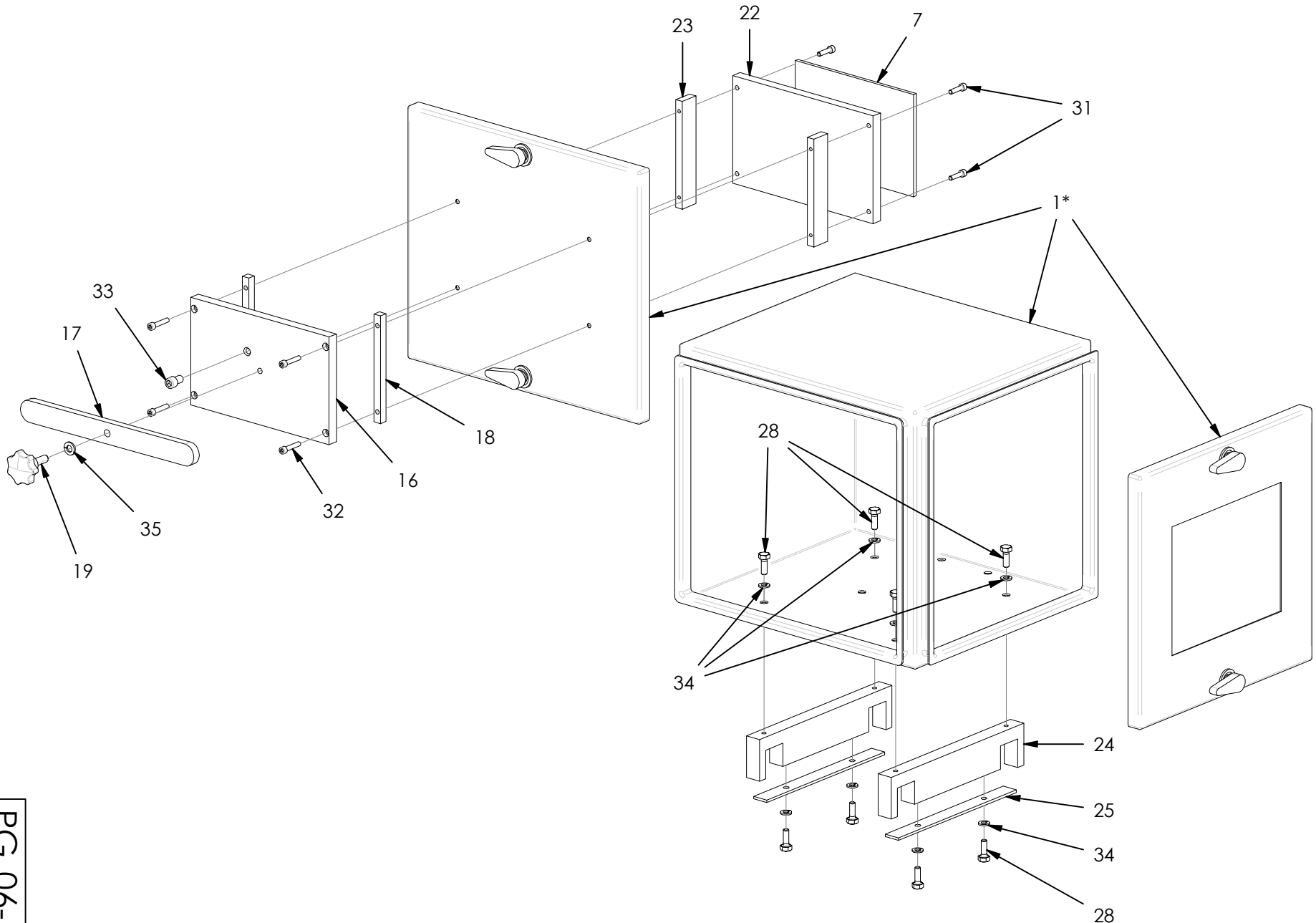
02-19-21

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1506M21WD2V2 Markem Printer Bracket Assembly



1506M21WD2V2 Markem Printer Bracket Assembly

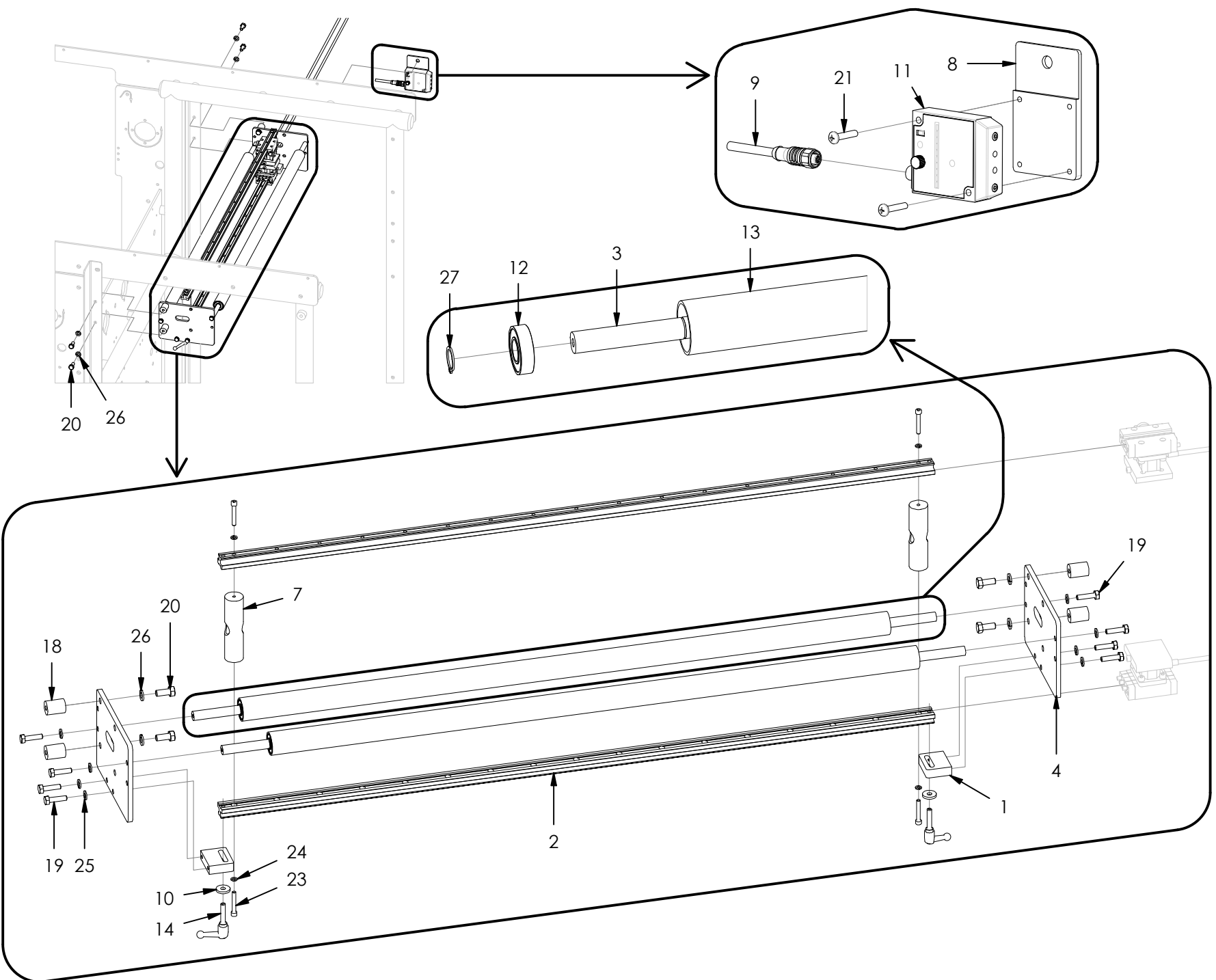


* Denotes a sub-assembly, consisting of multiple components.

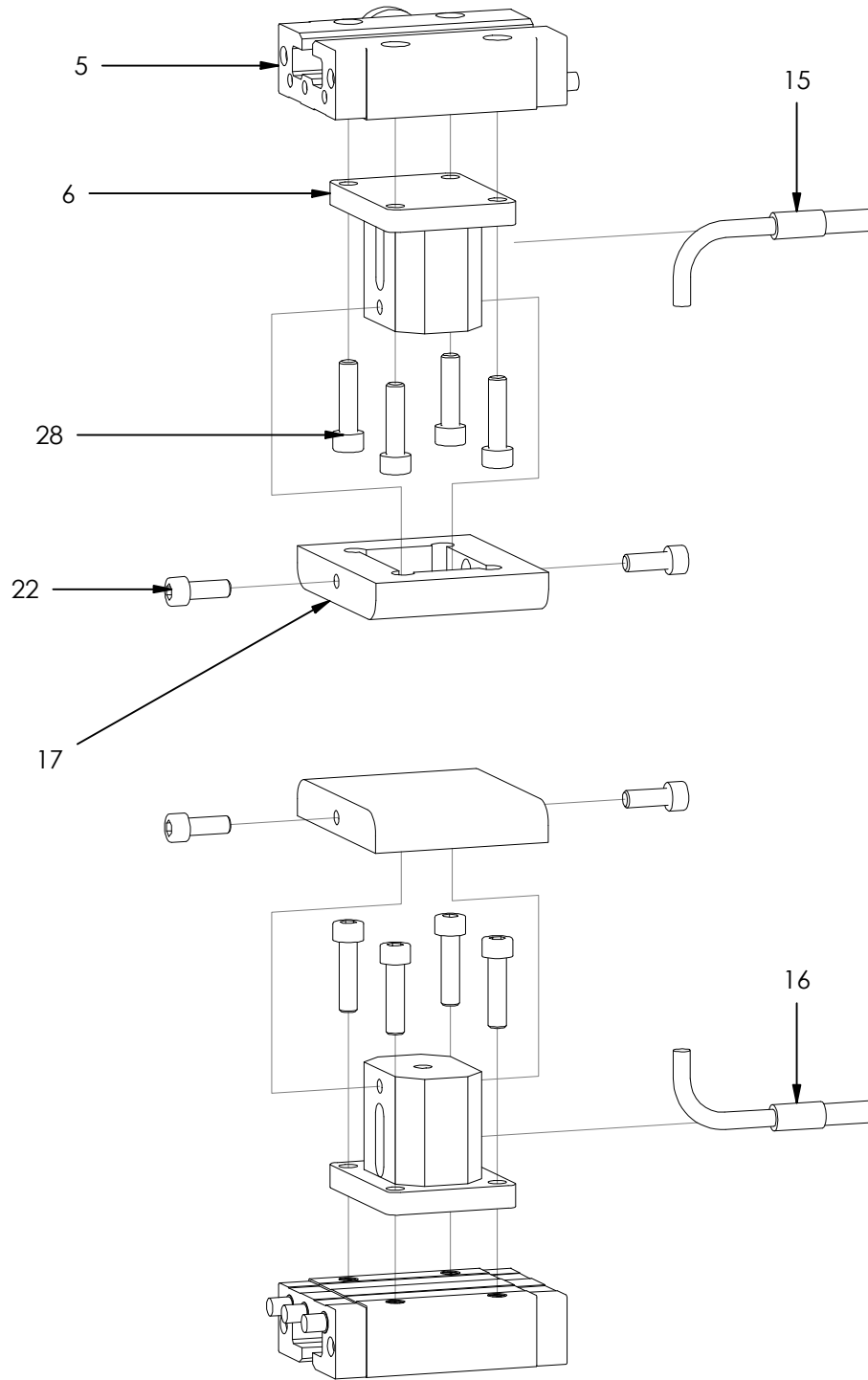
1506M2IWD2V2 Markem Printer Bracket Assembly

ITEM	PART NUMBER	DESCRIPTION	QTY
1	9506-0100	Printhead Washdown Enclosure	1
2	1506-0077	Stud Shaft	1
3	1506-0078V2	Gear Shaft	1
4	1506-0110	Bracket	4
5	1506-0111V2	Side Frame, M2IWD	2
6	1606-0127	Bolt, Shoulder	10
7	5300618	Anvil Rubber	1
8	9200-0038	Bearing	2
9	9200-0062	Flat Washer	1
10	9207-0032	Handle	1
11	9500-25	Bearing	10
12	9500-65	Roller	5
13	9506-0001	Gear Rack	2
14	9506-0009	Shaft	5
15	9506-0073	Roller	1
16	9506-0092 -1	Subplate	1
17	9506-0093	Locking Bar	1
18	9506-0094 -2	Spacer	2
19	9506-0095	Knob	1
20	9506-0101	Shaft	2
21	9506-0102	Shaft	2
22	9506-0107 -1	Back Up Plate	1
23	9506-0107 -2	Spacer	2
24	9506-0108 -1	Printer Mount	2
25	9506-0108 -2	Strap	2
26	1/4-20X3/4FB	Flange Bolt	8
27	3/8-16X1FB	Flange Bolt	8
28	1/4-20X3/4HH	Hex Head Bolt	16
29	1/4-20X1HH	Hex Head Bolt	12
30	5/16-18X1HH	Hex Head Bolt	1
31	10-32X3/4SH	Socket Head Bolt	4
32	10-32X1SH	Socket Head Bolt	4
33	5/16-18X1/2SH	Socket Head Bolt	1
34	1/4LW	Lock Washer	28
35	5/16LW	Lock Washer	3
36	1/2EXT	Snap Ring	10
37	3/4EXT	Snap Ring	2

1506SM Print Registration Assembly



1506SM Print Registration Assembly

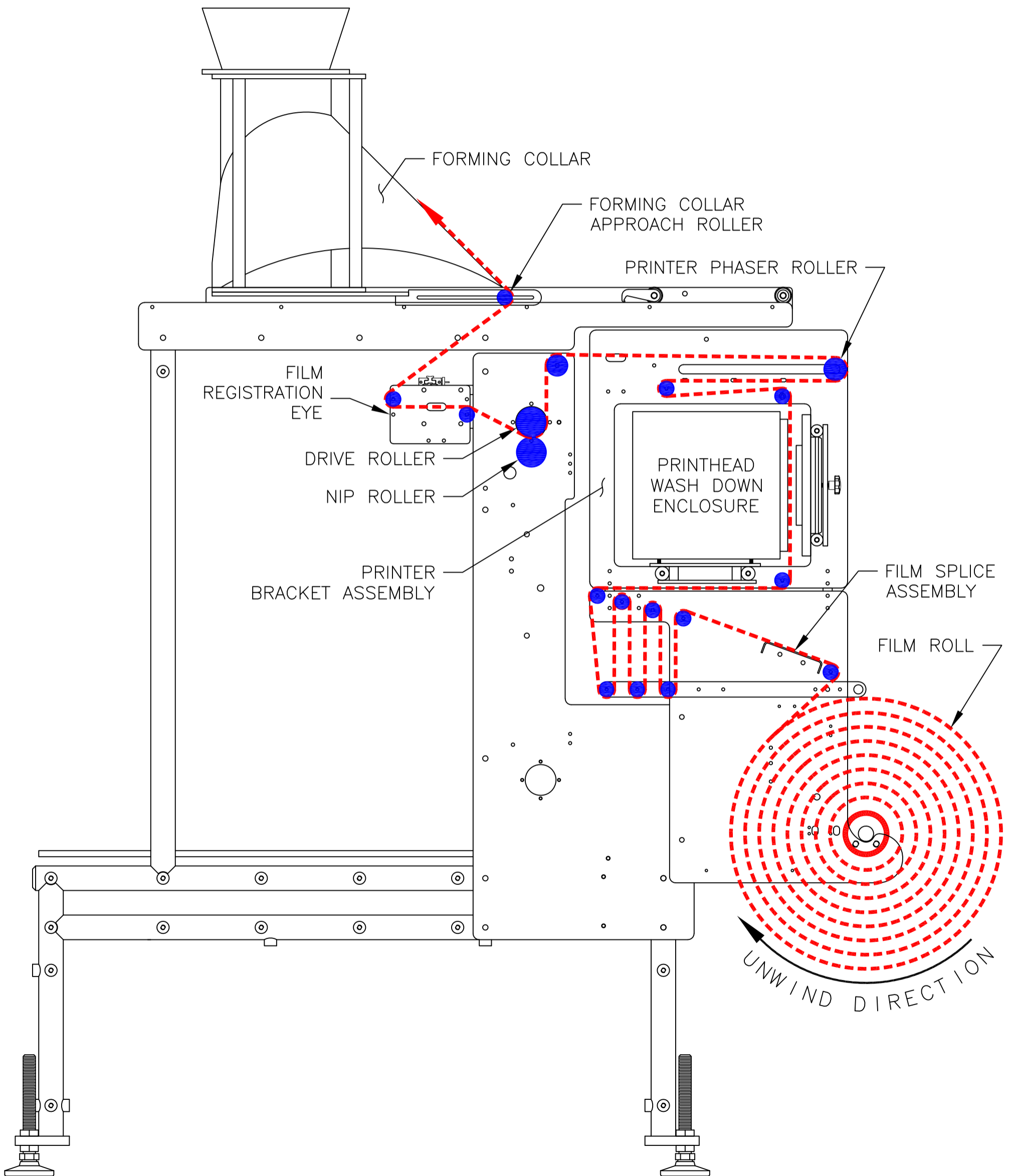


1506SM Print Registration Assembly

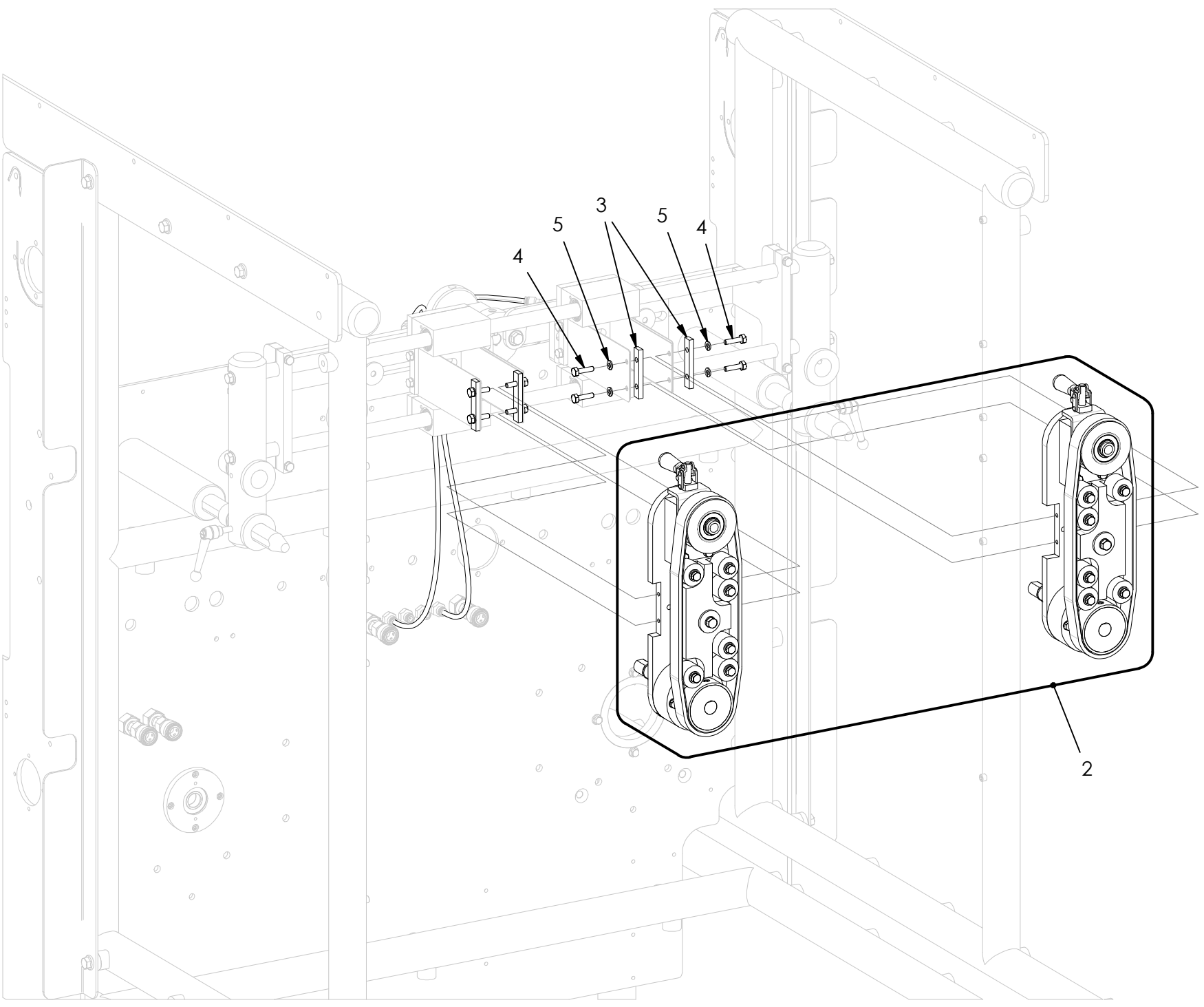
ITEM	PART NUMBER	DESCRIPTION	QTY
1	1506-0220	Rail Mount	2
2	1506-0222	Rail	2
3	1506-0226	Roller Shaft	2
4	1506-0230	Side Plate	2
5	1606-0121	Carriage	2
6	1606-0123	Eye Bracket	2
7	1606-0124	Spacer	2
8	1606-0125	Smart Eye Bracket	1
9	9200-0070	Straight Sensor Cable	1
10	9208-0016	Washer	2
11	9218-0006	Print Registration Base	1
12	9500-25	Bearing	4
13	9500-65	Roller	2
14	9506-0008	Handle	2
15	9506-0014	Fiber Optic Cable	1
16	9506-0060	Fiber Optic Cable	1
17	9506-0067	Eye Plate	2
18	9549-0018JS	Spacer	4
19	1/4-20X1HH	Hex Head Bolt	8
20	5/16-18X3/4HH	Hex Head Bolt	8
21	10-32X1PPH	Phillips Pan Head Screw	2
22	10-32X1/2SH	Socket Head Bolt	4
23	10-32X1 1/4SH	Socket Head Bolt	4
24	#10LW	Lock Washer	4
25	1/4LW	Lock Washer	8
26	5/16LW	Lock Washer	8
27	1/2EXT	Snap Ring	4
28	M5X20SH	Socket Head Bolt	8

PACMAC MODEL 2015 FILM THREADING DIAGRAM

1506M2IWDV2 PRINTER BRACKET ASSEMBLY AND 1506SM FILM REGISTRATION EYE



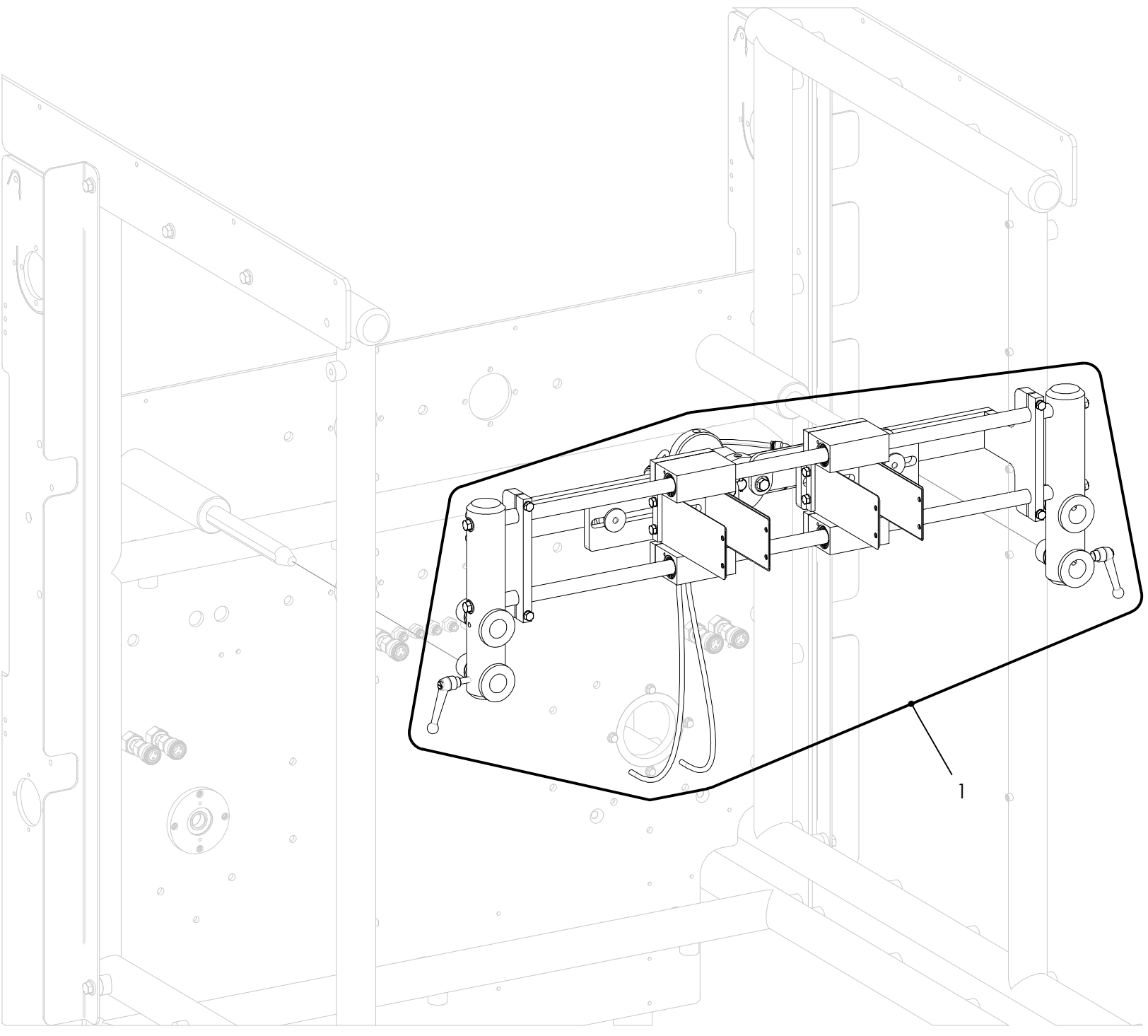
1511 Pull Belt Assembly



11-01-19

PG 11-01

1511 Pull Belt Assembly

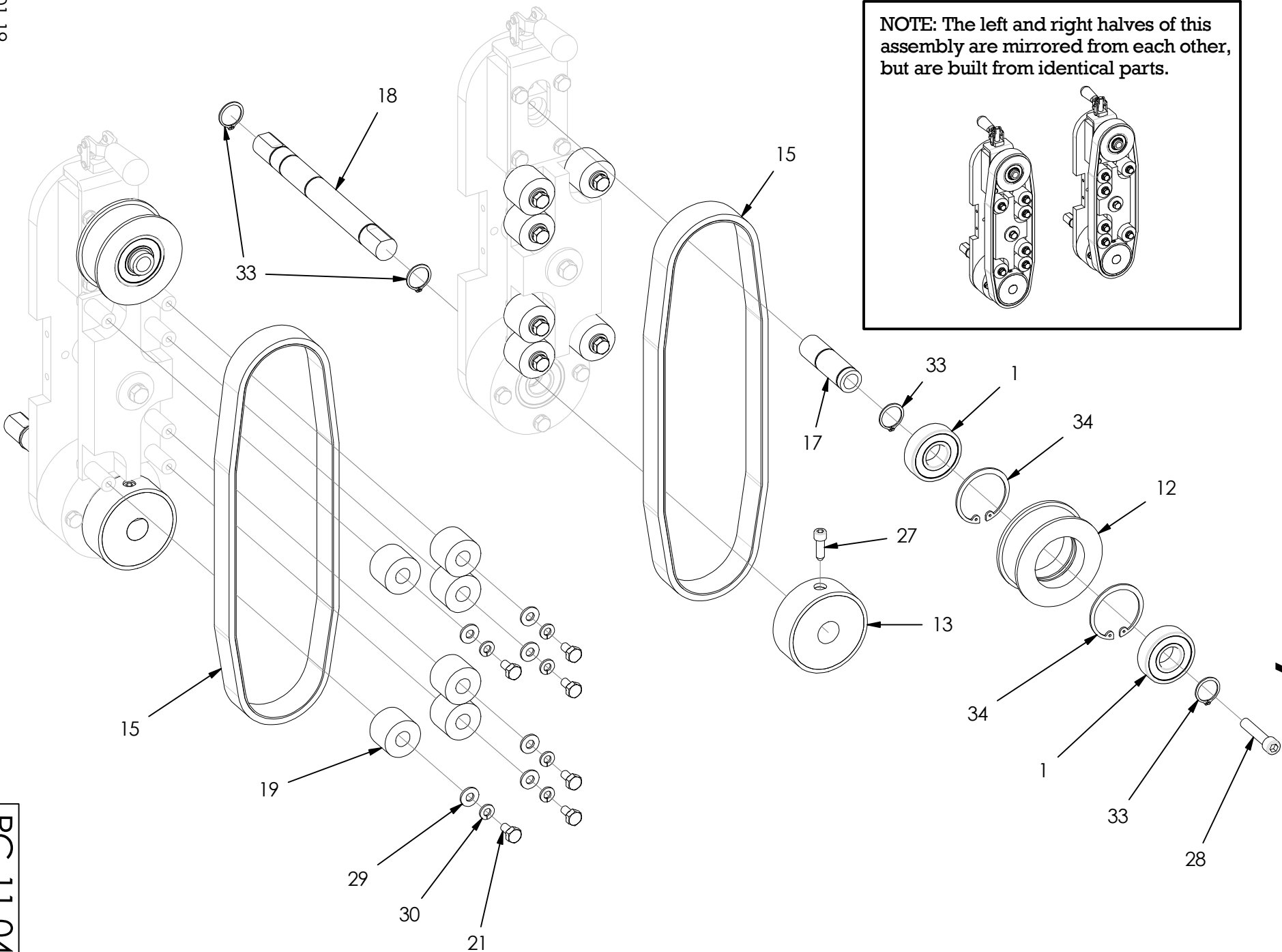


1511 Pull Belt Assembly

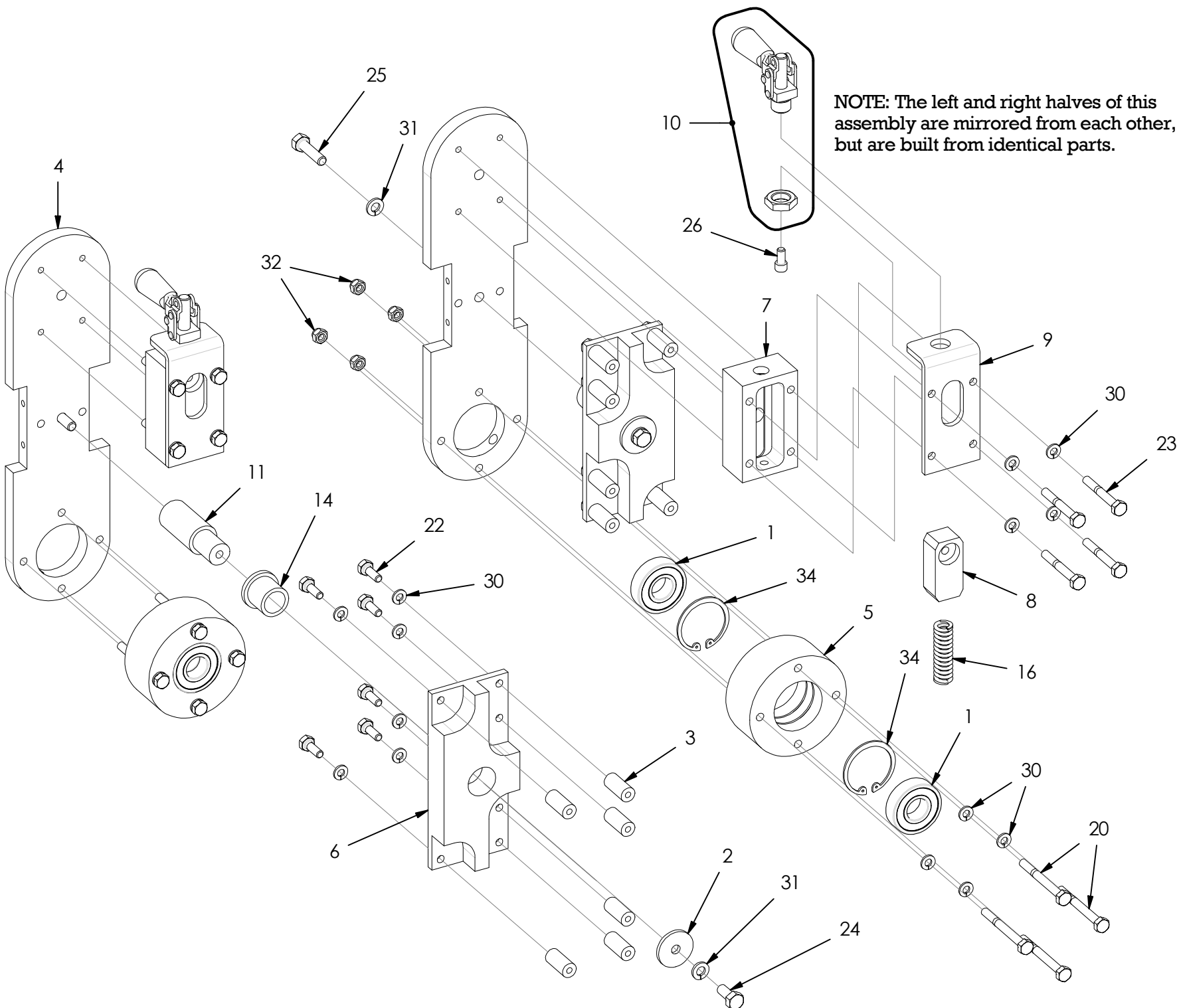
ITEM	PART NUMBER	DESCRIPTION	QTY
1	1511S	Slide Assembly	1
2	9511B	Belt Assembly	1
3	9211-0038	Flat Washer	4
4	1/4-20X1HH	Hex Head Bolt	8
5	1/4LW	Lock Washer	8

9511B Belt Assembly

NOTE: The left and right halves of this assembly are mirrored from each other, but are built from identical parts.



9511B Belt Assembly

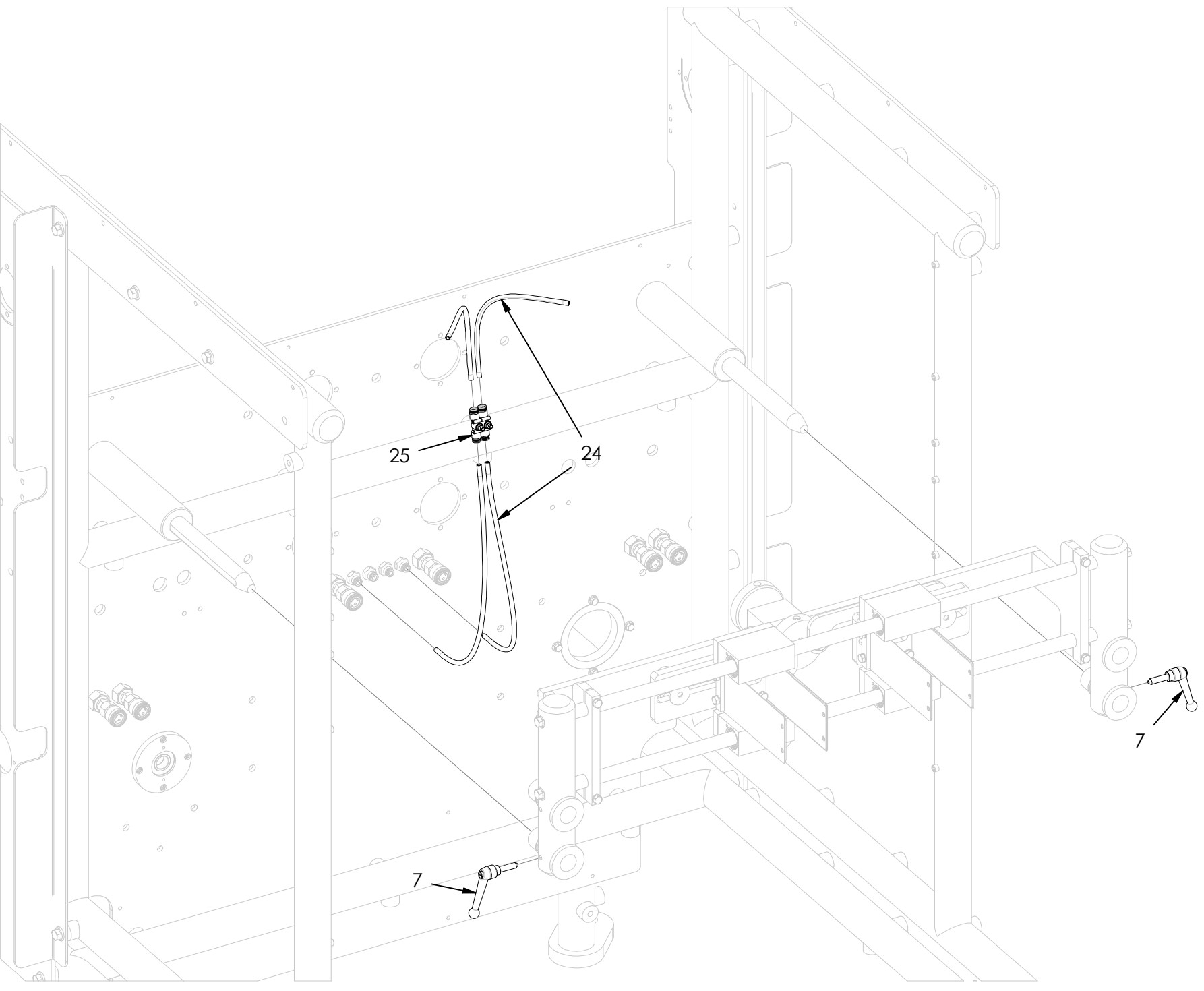


NOTE: The left and right halves of this assembly are mirrored from each other, but are built from identical parts.

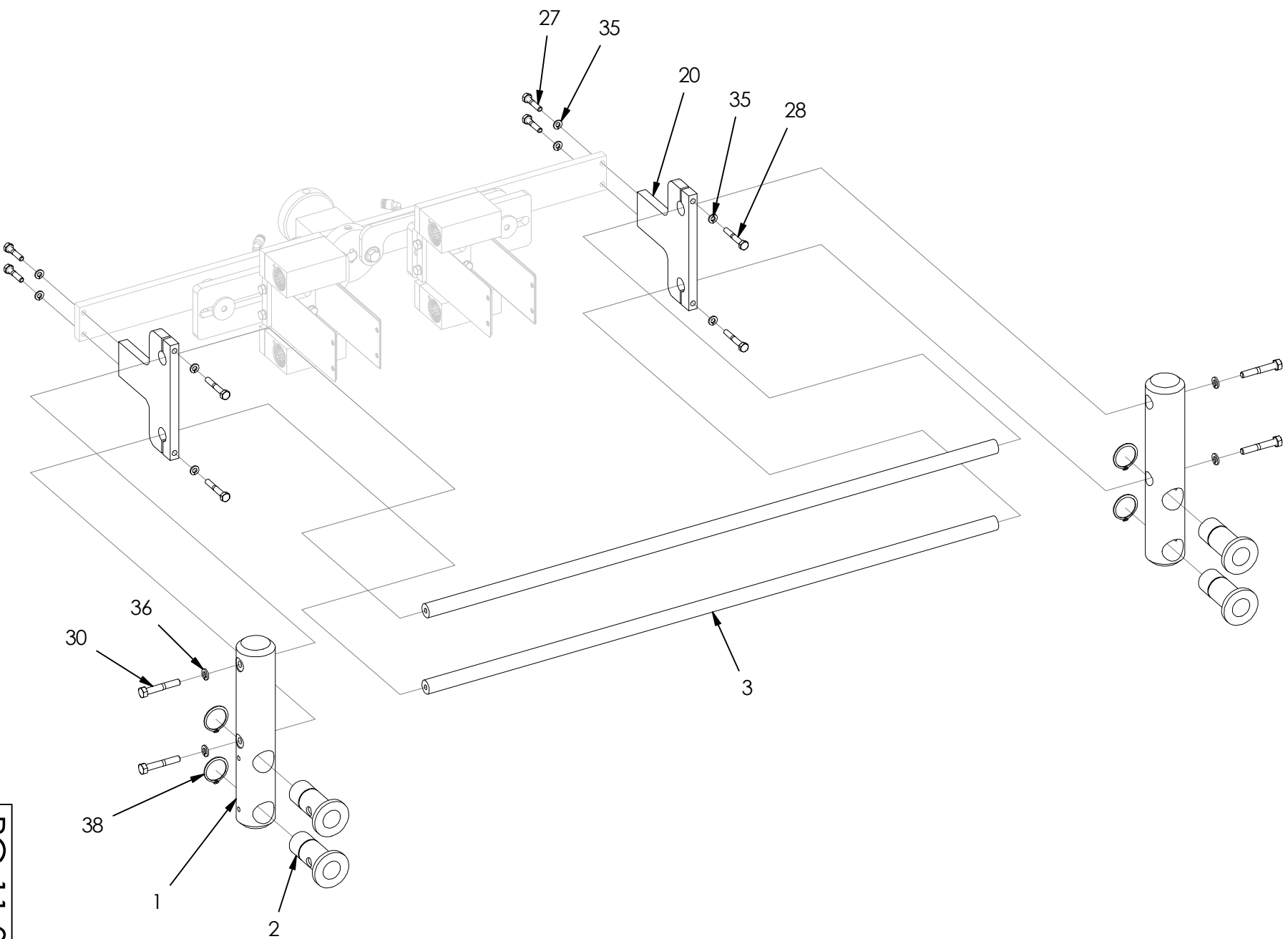
9511B Belt Assembly

ITEM	PART NUMBER	DESCRIPTION	QTY
1	9200-0038	Bearing	8
2	9200-0062	Flat Washer	2
3	9200-0067	Roller Shaft	12
4	9211-0006	Mounting Plate	2
5	9211-0007P	Bearing Housing	2
6	9211-0008	Pivot Plate	2
7	9211-0009	Tension Block Housing	2
8	9211-0010	Tension Block	2
9	9211-0011Z	Plate	2
10	9211-0011Z -1	Straight Line Clamp	2
11	9211-0012	Pivot Shaft	2
12	9211-0015-1	Idler Pully	2
13	9211-0016	Drive Pulley	2
14	9211-0018	Bushing	2
15	9211-0019	Pull Belt	2
16	9211-0020ZSS	Spring	2
17	9211-0026	Idler Shaft	2
18	9511-0013	Shaft	2
19	9511-0017	Roller	12
20	1/4-20X2 1/2HH	Hex Head Bolt	8
21	1/4-20X1/2HH	Hex Head Bolt	12
22	1/4-20X3/4HH	Hex Head Bolt	12
23	1/4-20X2HH	Hex Head Bolt	8
24	5/16-18X3/4HH	Hex Head Bolt	2
25	5/16-18X1 1/4HH	Hex Head Bolt	2
26	1/4-20X1/2SH	Socket Head Bolt	2
27	1/4-20X3/4SH	Socket Head Bolt (tapered)	2
28	5/16-18X1 1/2SH	Socket Head Bolt	2
29	1/4FW	Flat Washer	12
30	1/4LW	Lock Washer	40
31	5/16LW	Lock Washer	4
32	1/4-20LN	Lock Nut	8
33	3/4EXT	Snap Ring	8
34	1 3/4INT	Snap Ring	8

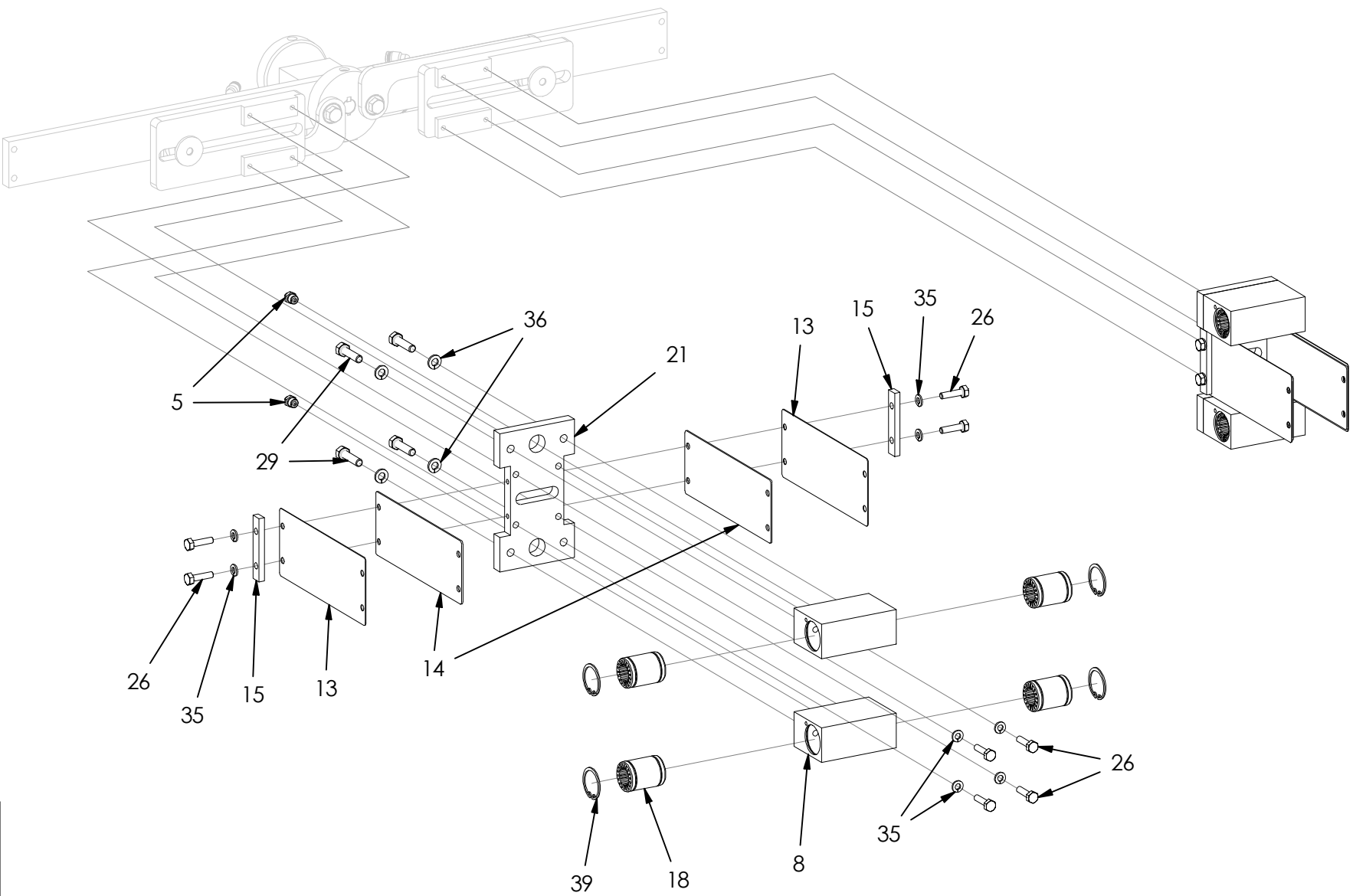
1511S Slide Assembly



1511S Slide Assembly

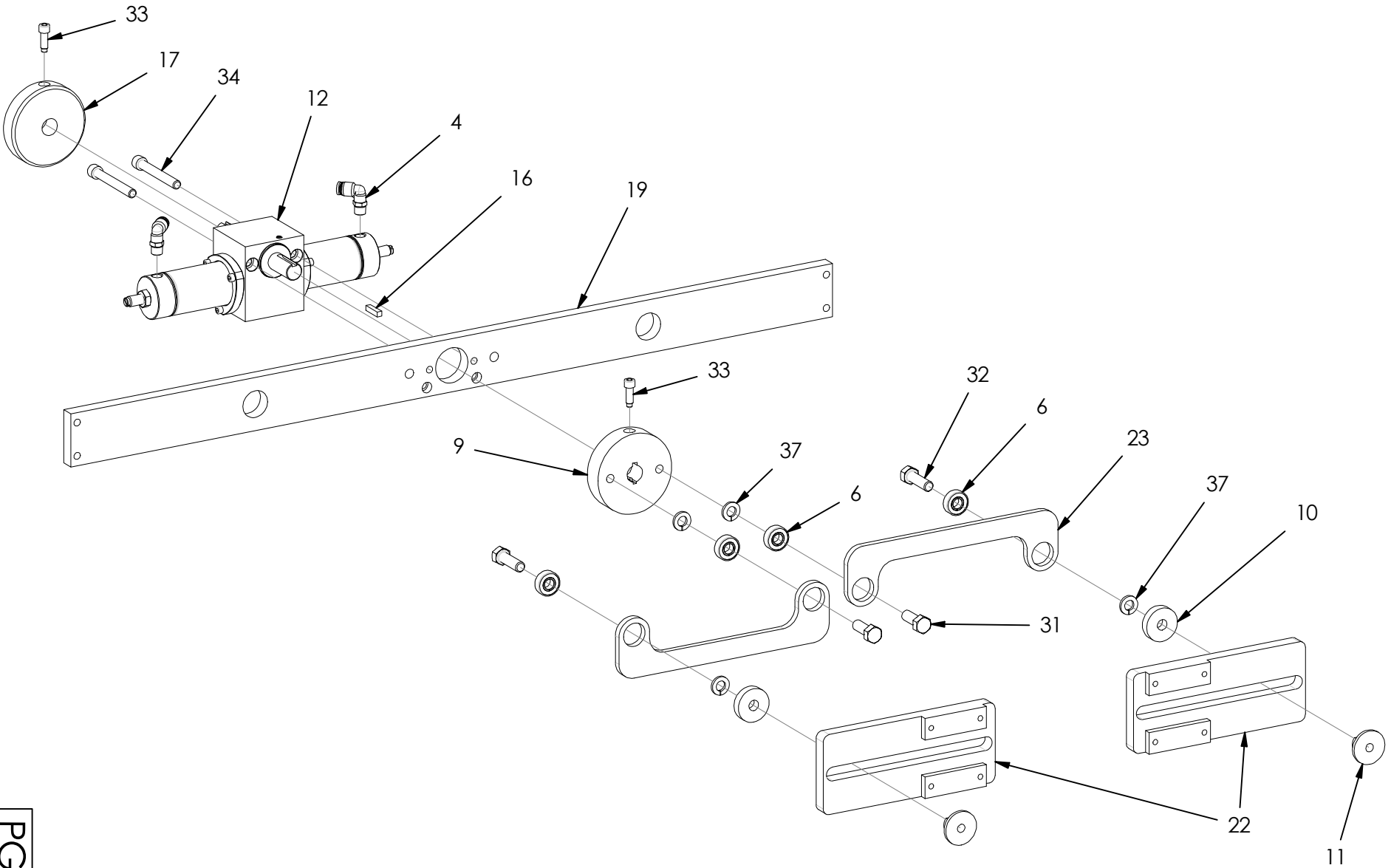


1511S Slide Assembly



1511S Slide Assembly

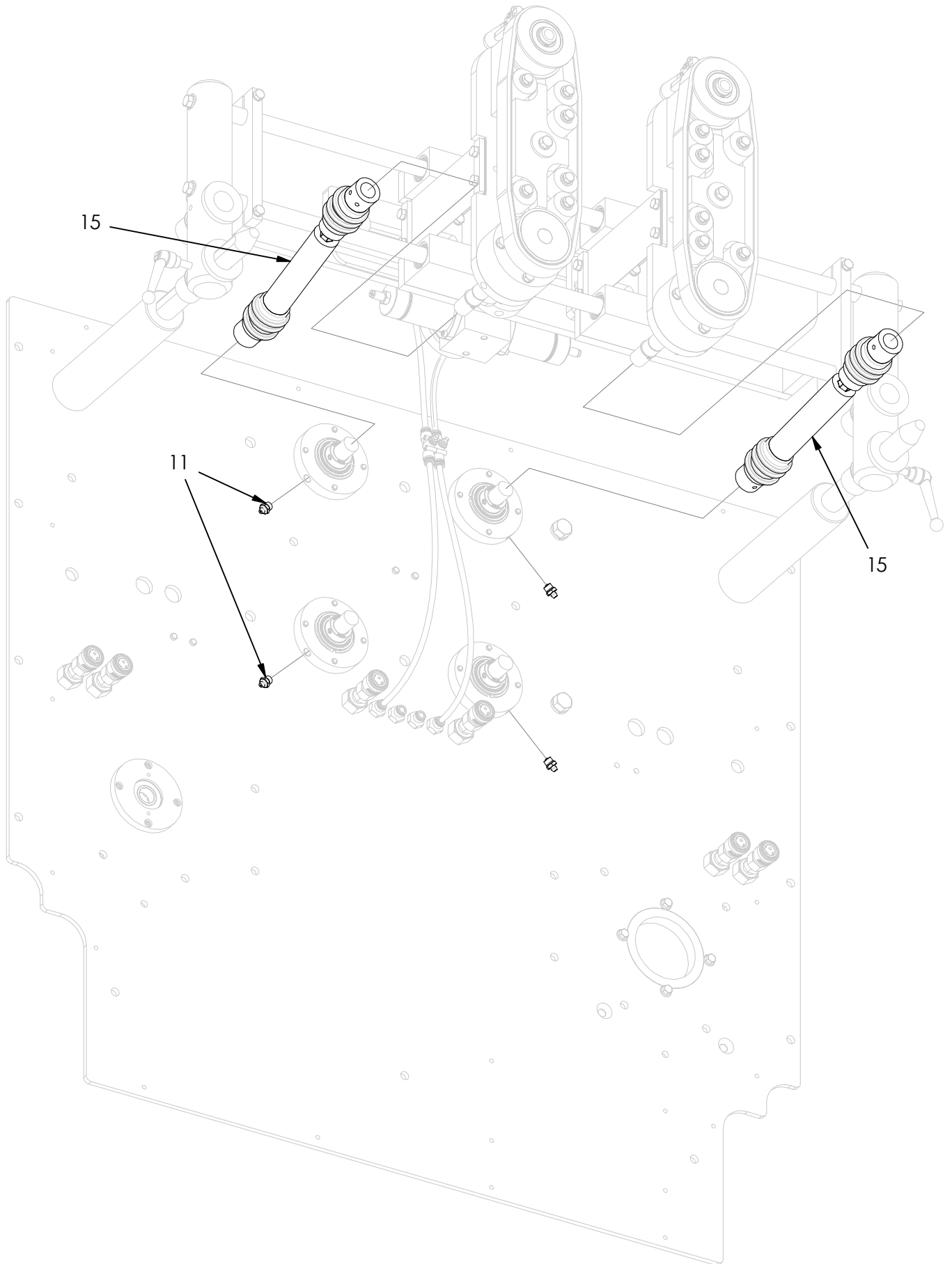
10-18-19



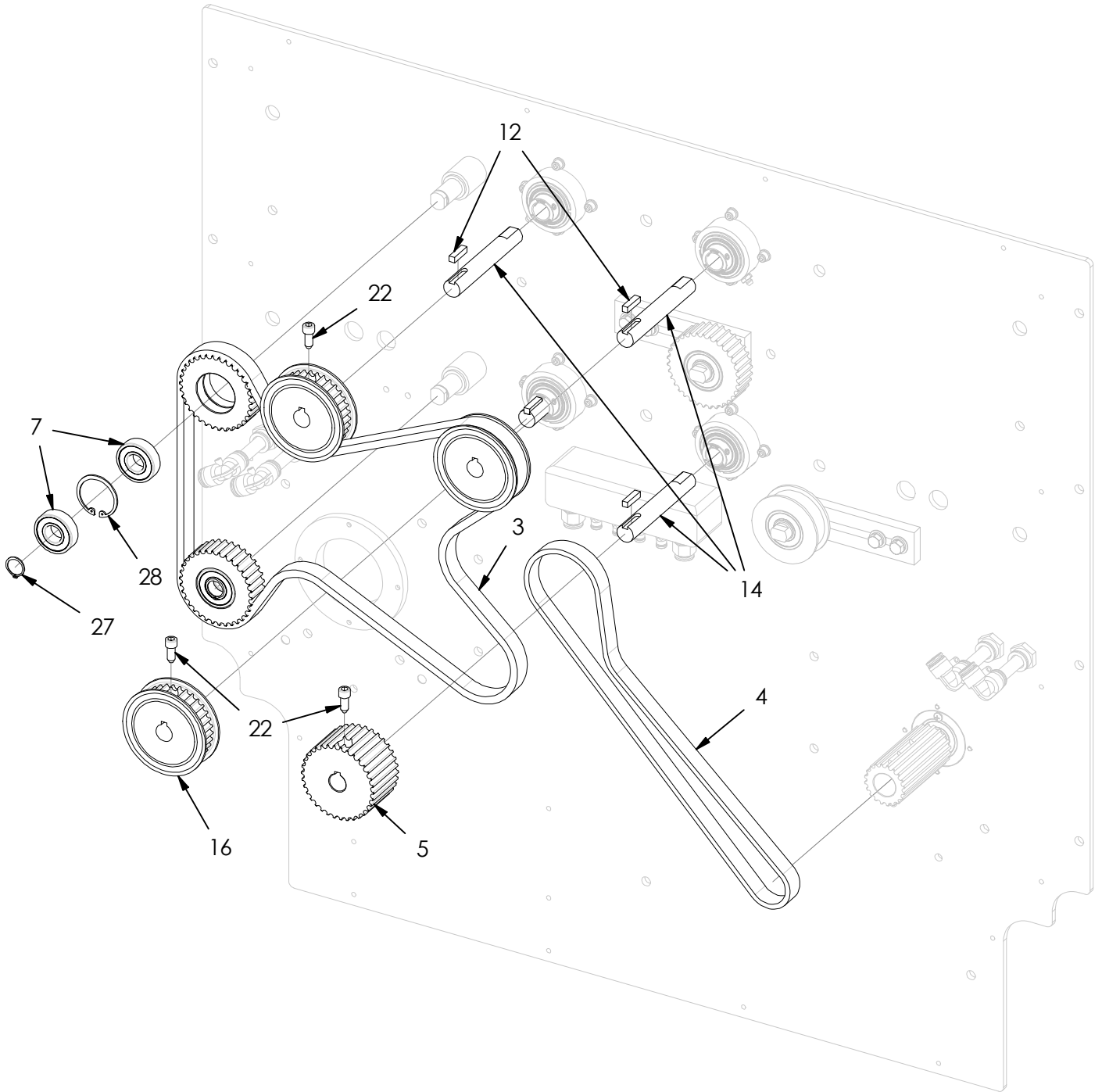
1511S Slide Assembly

ITEM	PART NUMBER	DESCRIPTION	QTY
1	1511-0006	Support Column	2
2	1511-0006 -1	Bushing	4
3	1511-0021	Linear Shaft	2
4	9200-0046	Tubing Connector	2
5	9200-0069	Grease Zerk	4
6	9200-0071	Bearing	4
7	9207-0032	Handle (tapered)	2
8	9211-0003	Linear Shaft Block	4
9	9211-0005	Circular Cam	1
10	9211-0028	Clamp Washer	2
11	9211-0032	Clamp Nut	2
12	9211-0035	Rotary Actuator	1
13	9211-0037	Flat Spring	4
14	9211-0037P	Flat Spring	4
15	9211-0038	Flat Washer	4
16	9211-0074	Key (1/8" X1")	1
17	9211-0087	Handwheel	1
18	9503-0058	Bushing	8
19	9511-0001	Frame Member	1
20	9511-0002	Linear Shaft Support	2
21	9511-0004	Side Plate	2
22	9511-0008	Slide Plate	2
23	9511-0022	Mayme Lever	2
24	9511-A001	Slide Assy Tubing Kit	1
25	9516-0050	Flow Control	2
26	1/4-20X1HH	Hex Head Bolt	16
27	1/4-20X1 1/4HH	Hex Head Bolt	4
28	1/4-20X1 3/4HH	Hex Head Bolt	4
29	5/16-18X1 1/4HH	Hex Head Bolt	8
30	5/16-18X2HH	Hex Head Bolt	4
31	3/8-16X1HH	Hex Head Bolt	2
32	3/8-16X1 1/4HH	Hex Head Bolt	2
34	5/16-18X2 1/2SH	Socket Head Bolt	2
33	1/4-20X3/4SHDP	Socket Head Dogpoint Bolt	2
35	1/4LW	Lock Washer	24
36	5/16LW	Lock Washer	12
37	3/8LW	Lock Washer	4
38	1 1/4EXT	Snap Ring	4
39	1 1/4INT	Snap Ring	8

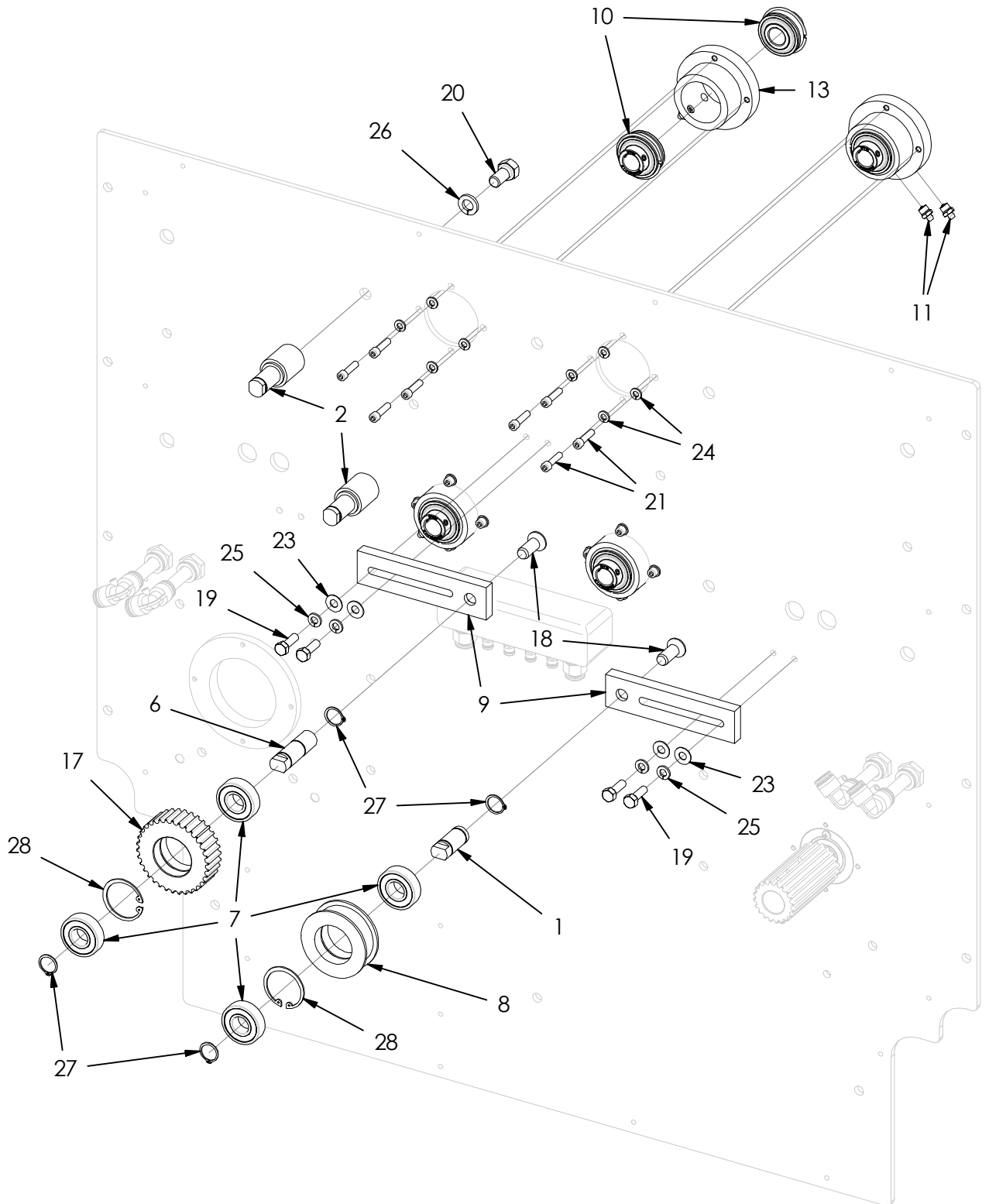
1511T Transmission Assembly



1511T Transmission Assembly



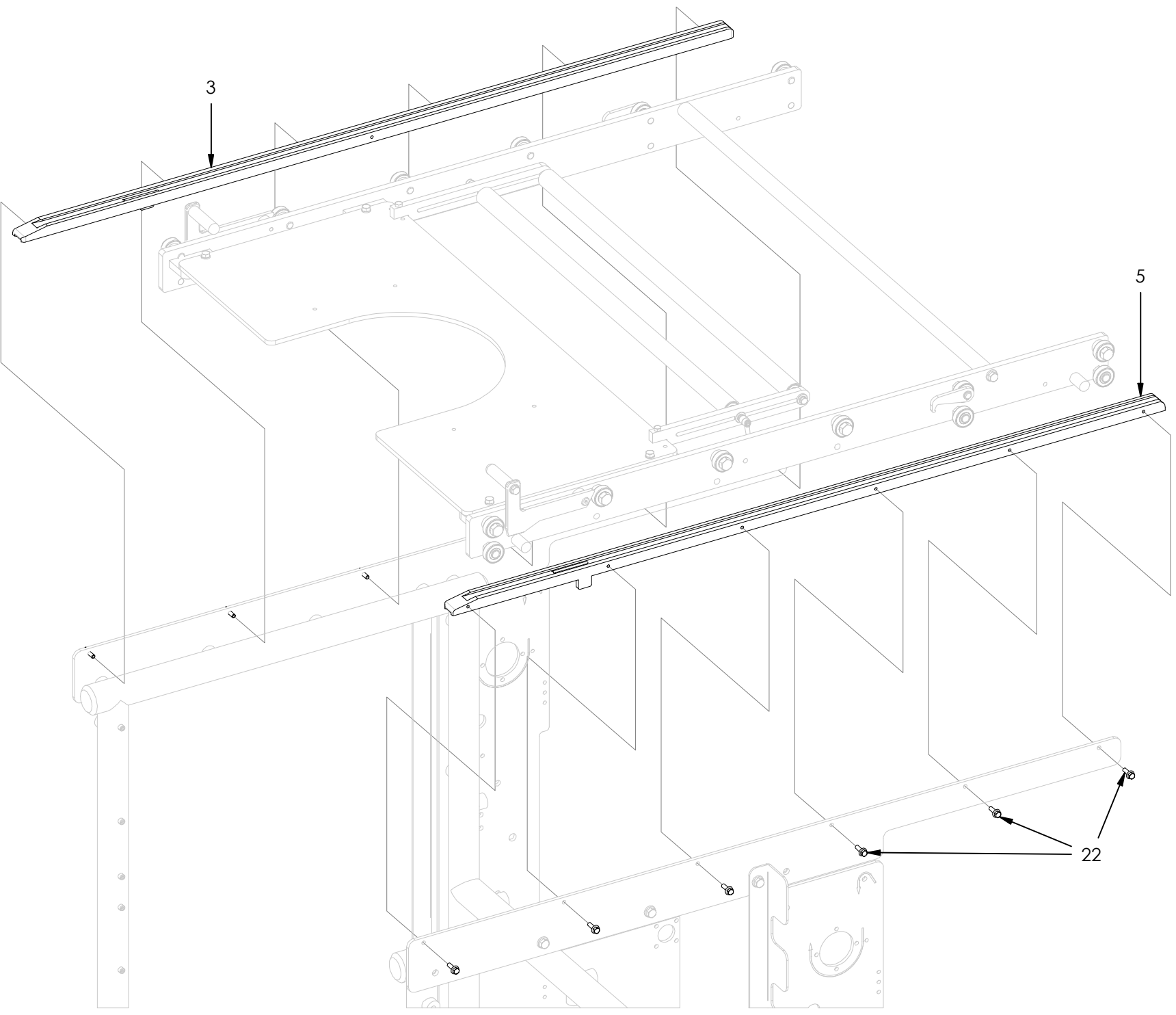
1511T Transmission Assembly



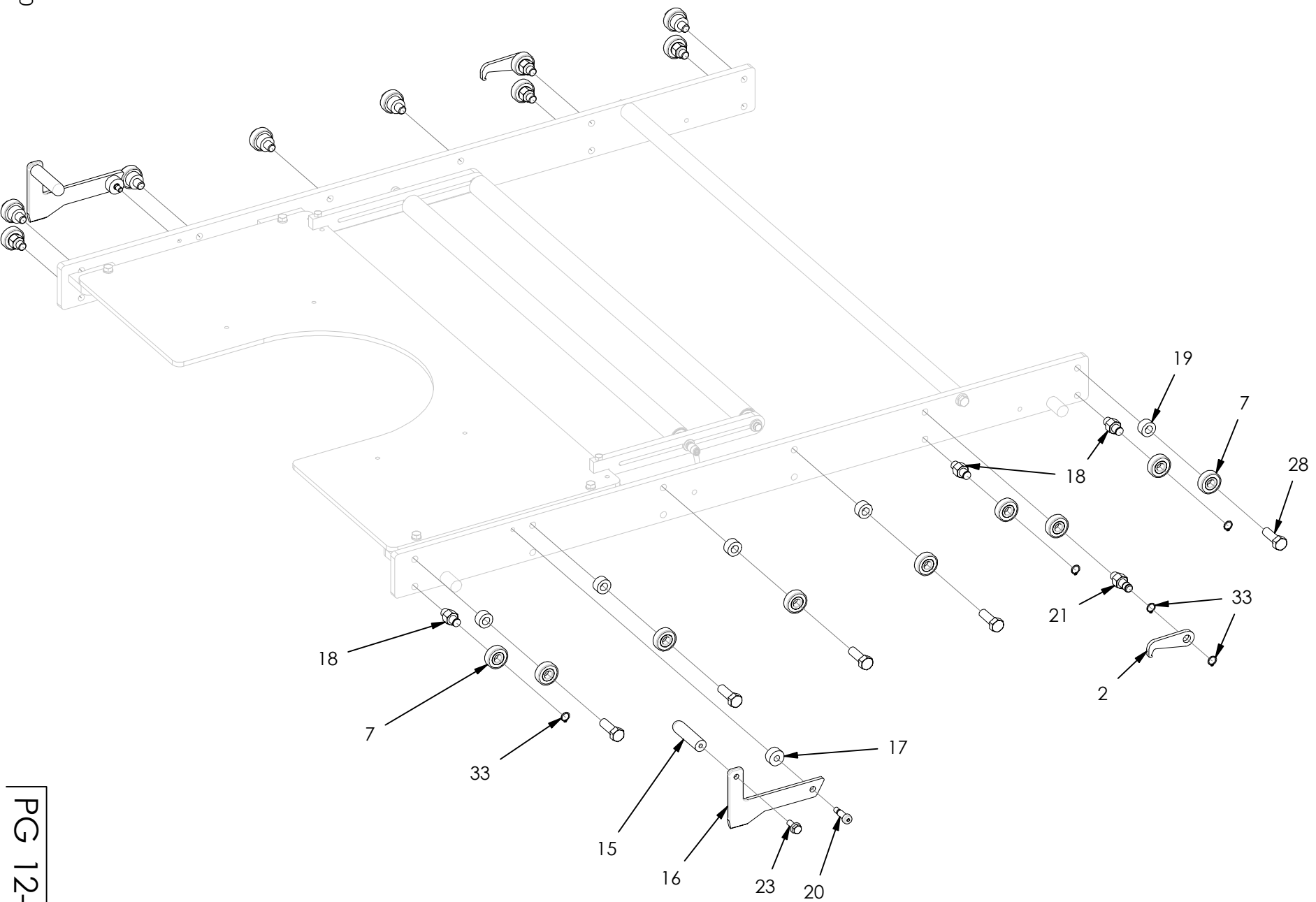
1511T Transmission Assembly

ITEM	PART NUMBER	DESCRIPTION	QTY
1	1500-29	Stud	1
2	1511-0033	Stud	2
3	1511-0059	Twin Power Timing Belt	1
4	1511-0061	Timing Belt	1
5	1511-0101	Dual Cog	1
6	1511-0102	Idler Stud	1
7	9200-0038	Bearing	8
8	9200-0043	Tension Idler	1
9	9200-0045	Idler Slide Plate	2
10	9200-0050SS	Bearing	8
11	9200-0069	Grease Zerk	7
12	9202-0051	Key (5/16" X1")	4
13	9211-0014	Bearing Housing	4
14	9211-0025	Shaft	4
15	9211-0027	Universal Joint	2
16	9211-0049	Drive Cog	3
17	9211-0034	Cog	3
18	1/2-13X1 1/4FH	Flat Head Bolt	2
19	5/16-18X1HH	Hex Head Bolt	4
20	1/2-13X1HH	Hex Head Bolt	2
21	1/4-20X1SH	Socket Head Bolt	16
22	5/16-18X3/4SH	Socket Head Bolt	4
23	5/16FW	Flat Washer	4
24	1/4LW	Lock Washer	16
25	5/16LW	Lock Washer	4
26	1/2LW	Lock Washer	2
27	3/4EXT	Snap Ring	6
28	1 3/4INT	Snap Ring	4

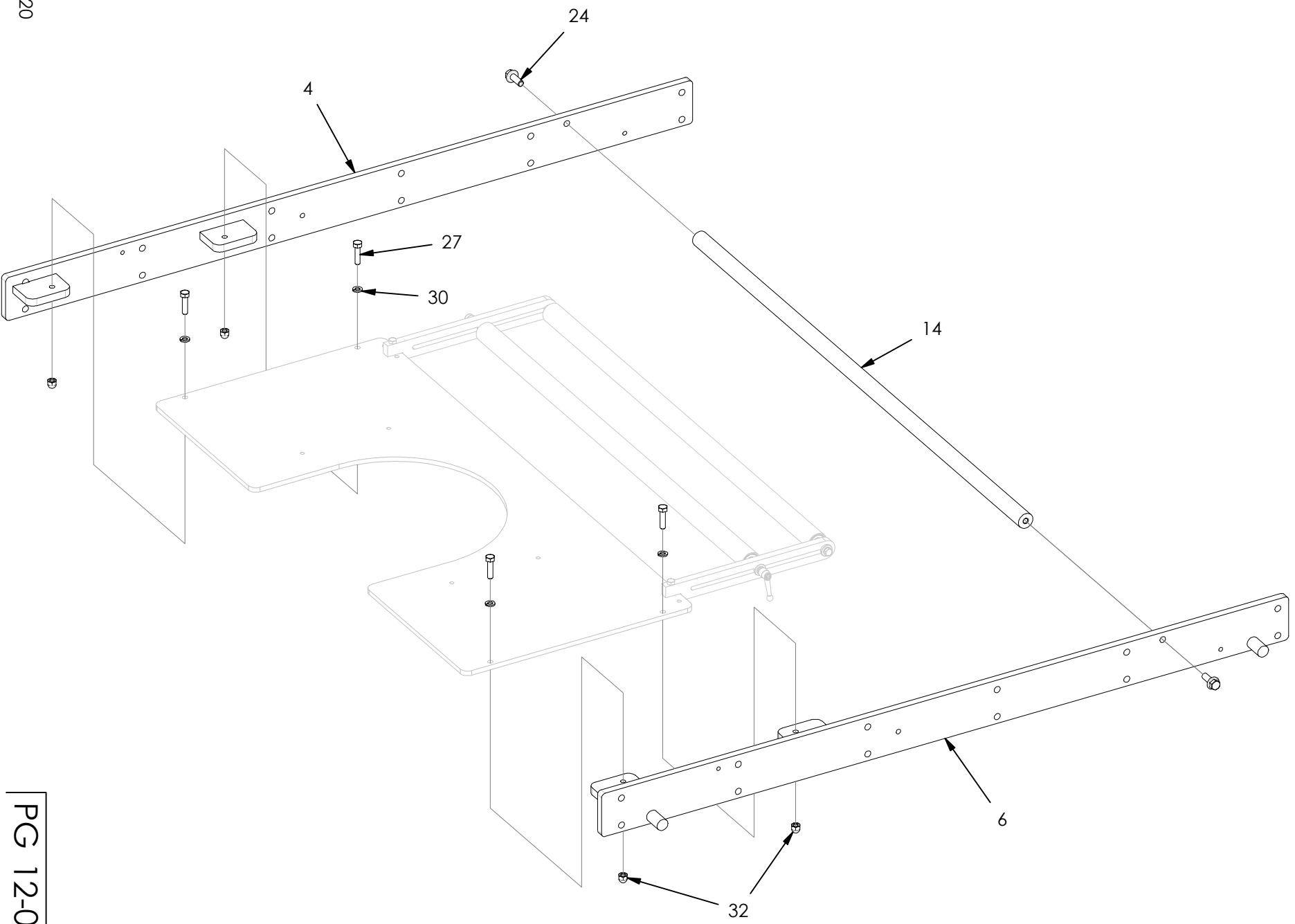
1512 Tube Side Assembly



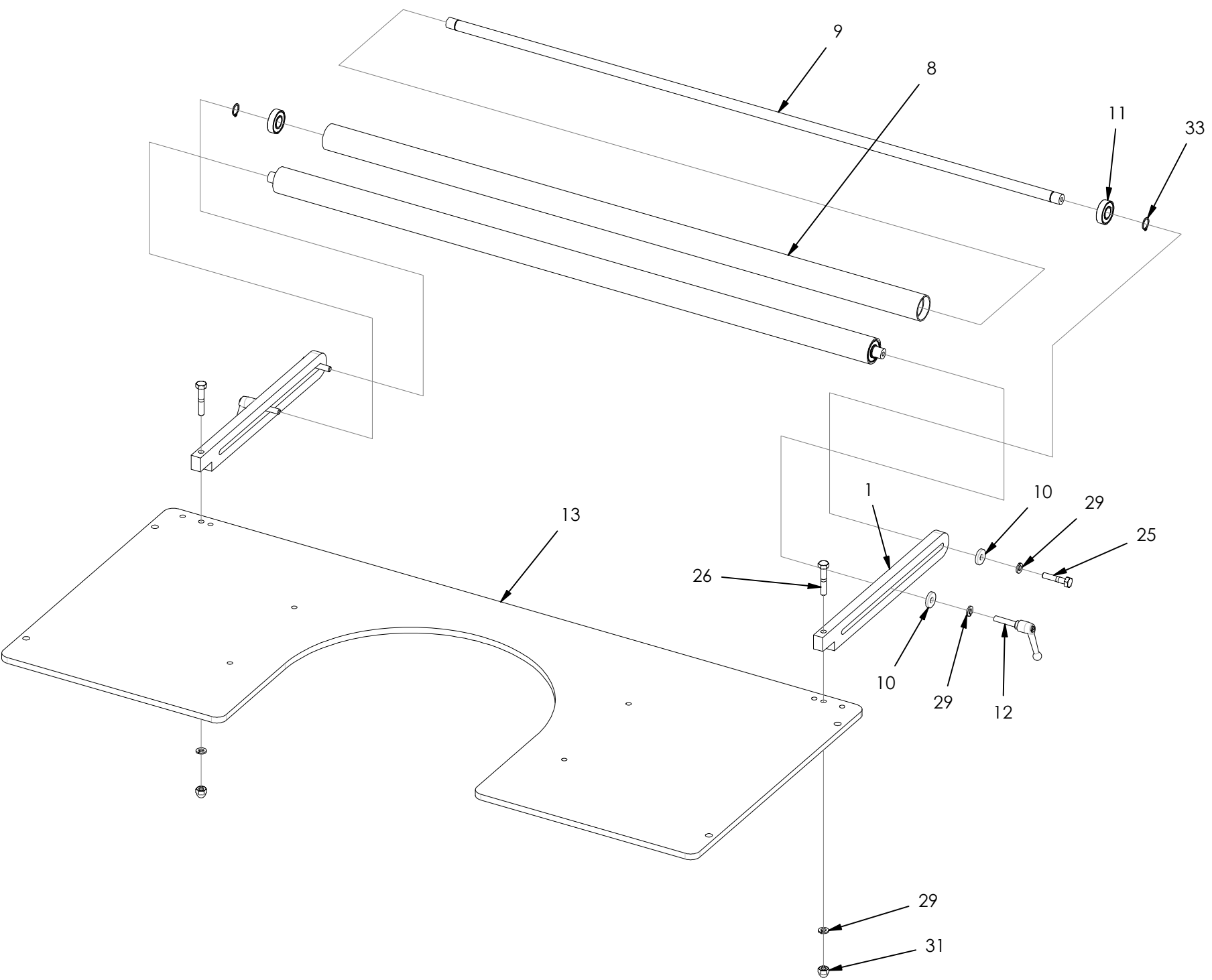
1512 Tube Side Assembly



1512 Tube Side Assembly



1512 Tube Side Assembly



1512 Tube Slide Assembly

ITEM	PART NUMBER	DESCRIPTION	QTY
1	1500-91	Bar -9-8-7	2
2	1512-0013 -9	Extended Lock	2
3	1512-0013L -1	Rail	1
4	1512-0013L -2	Roller Bracket	1
5	1512-0013R -1	Rail	1
6	1512-0013R -2	Roller Bracket	1
7	9200-0053	Bearing	18
8	9200-0090X32	Roller	2
9	9200-0092X33	Shaft	2
10	9208-0016	Washer	4
11	9500-25	Bearing	4
12	9506-0008	Handle	2
13	9512-0004V4	Mounting Plate	1
14	9512-0013 -1	Cross Shaft	1
15	9512-0013 -10	Handle	2
16	9512-0013 -3	Slide Lock	2
17	9512-0013 -4	Slide Lock Spacer	2
18	9512-0013 -5	Hex Stud	6
19	9512-0013 -6	Bearing Spacer	10
20	9512-0013 -7	Shoulder Bolt	2
21	9512-0013 -8	Hex Stud	2
22	1/4-20X3/4FB	Flange Bolt	12
23	5/16-18 X3/4FB	Flange Bolt	2
24	3/8-16X1FB	Flange Bolt	2
25	1/4-20X1 1/4HH	Hex Head Bolt	2
26	1/4-20X1 1/2HH	Hex Head Bolt	2
27	5/16-18 X1.25HH	Hex Head Bolt	4
28	1/2-13X1 1/2HH	Hex Head Bolt	10
29	1/4LW	Lock Washer	6
30	5/16LW	Lock Washer	4
31	1/4-20AN	Acorn Nut	2
32	5/16-18AN	Acorn Nut	4
33	1/2EXT	Snap Ring	14

PACMAC, INCORPORATED
 MODEL 9500
 VERTICAL FORM, FILL
 AND SEAL MACHINE
 1512PB-14 FORMING TUBE ASSEMBLY

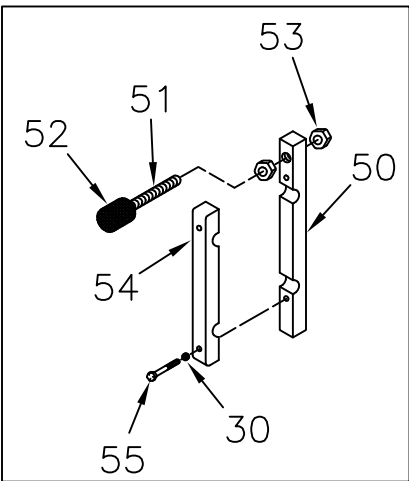
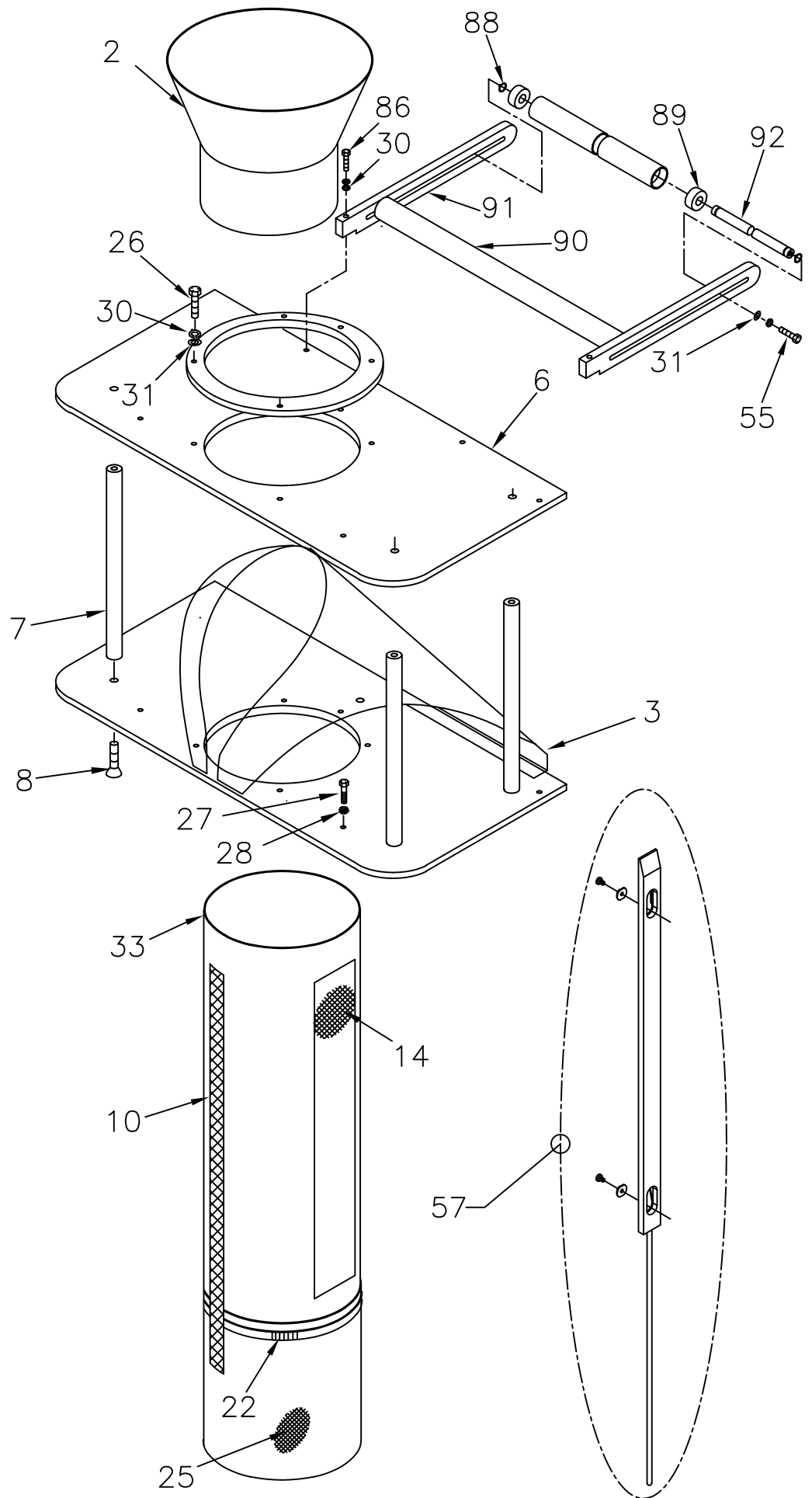
ITEM	PART NUMBER	DESCRIPTION	QTY
2	F5A-14-12X12*	FUNNEL	1
3	9512-0003-14	FORMING COLLAR	1
6	9512-0006-14	UPPER SUPPORT PLATE	1
7	9212-0007-14	SUPPORT SHAFT	4
8	5/16-18X1FH	FLAT HEAD	8
10	9512-0010	SILICONE STRIP	AR
14	9212-0014	2" TFE TAPE	AR
22	9512-0022-14	BAND	1
25	9212-0025-14.5	SKIRT	1
26	¼-20X¾HH	HEX HEAD BOLT	4
27	5/16-18X1 ¼HH	HEX HEAD BOLT	2
28	5/16LW	LOCK WASHER	2
30	¼LW	LOCK WASHER	6
31	¼FW	FLAT WASHER	4
33	9512-0033-14	FILLER TUBE	1
49	9212-0049	10" TFE TAPE (NOT SHOWN)	2
50	9512-0050	CLAMP	1
51	9512-0051	ALL THREAD	1
52	9512-0052	STOP	1
53	½-13HN	HEX NUT	2
54	9224-0009	CLAMP	1
55	¼-20X1 ¼HH	HEX HEAD BOLT	2

PACMAC, INCORPORATED
MODEL 9500
VERTICAL FORM, FILL
AND SEAL MACHINE
1512PB-14 FORMING TUBE ASSEMBLY

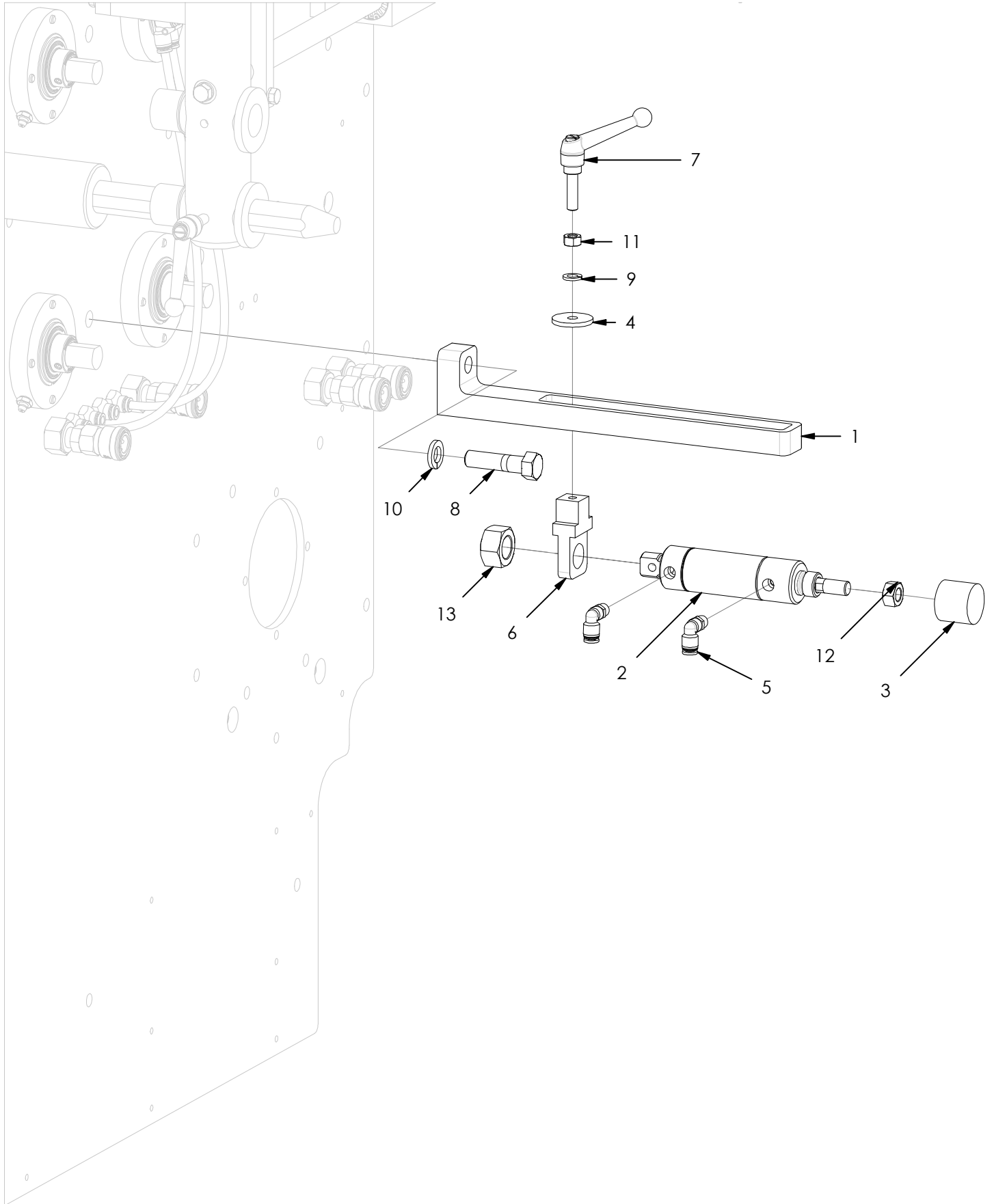
ITEM	PART NUMBER	DESCRIPTION	QTY
57	A9512-0034G-2S	GUSSET GUIDE ASSEMBLY	0
86	1/4-20X1 1/2HH	HEX HEAD BOLT	0
88	1/2EXT	SNAP RING	0
89	9200-25	BEARING	0
90	9200-0090	ROLLER	0
91	9200-0091	BAR	0
92	9200-0092	SHAFT	0

* SPECIFY: __. __ = SIZE

__X__ = RISE X DIAMETER



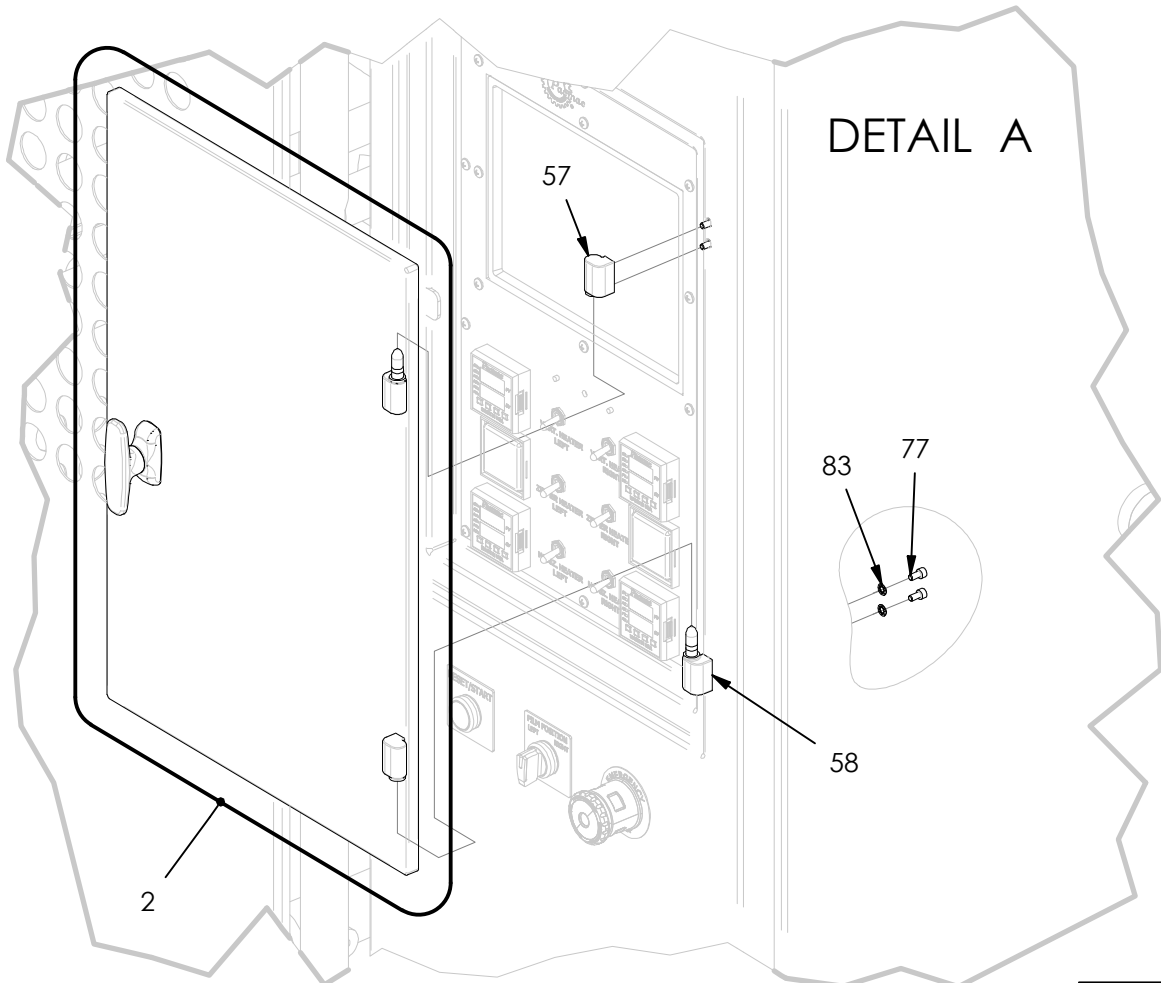
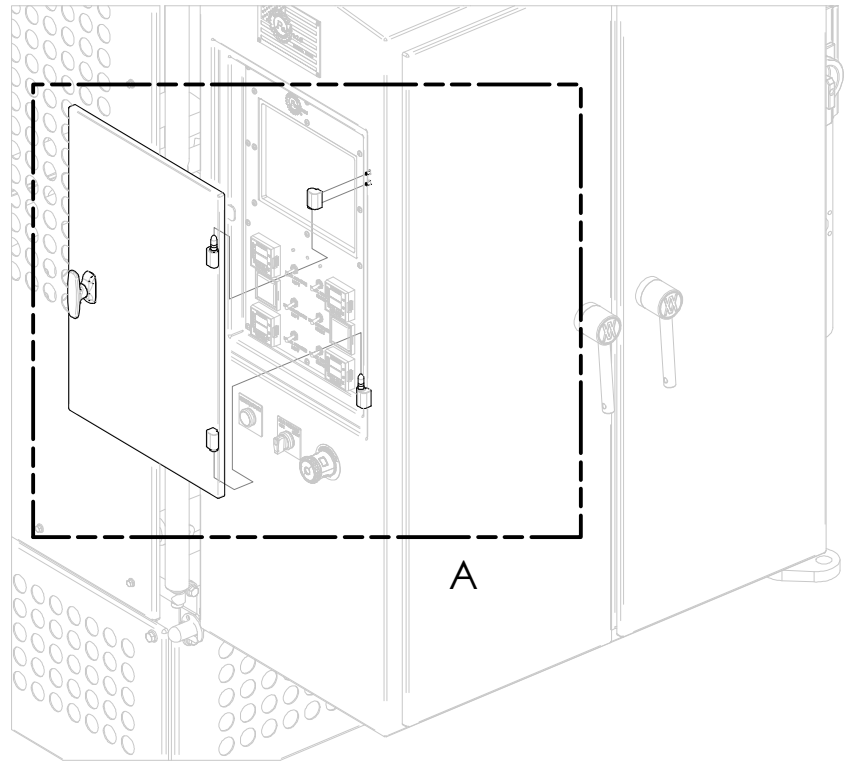
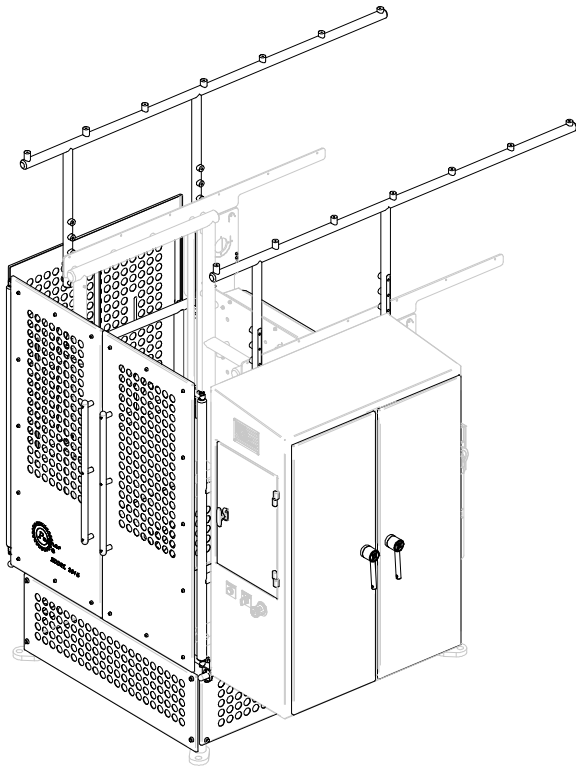
A9512-0065 Retractable Tube Stop

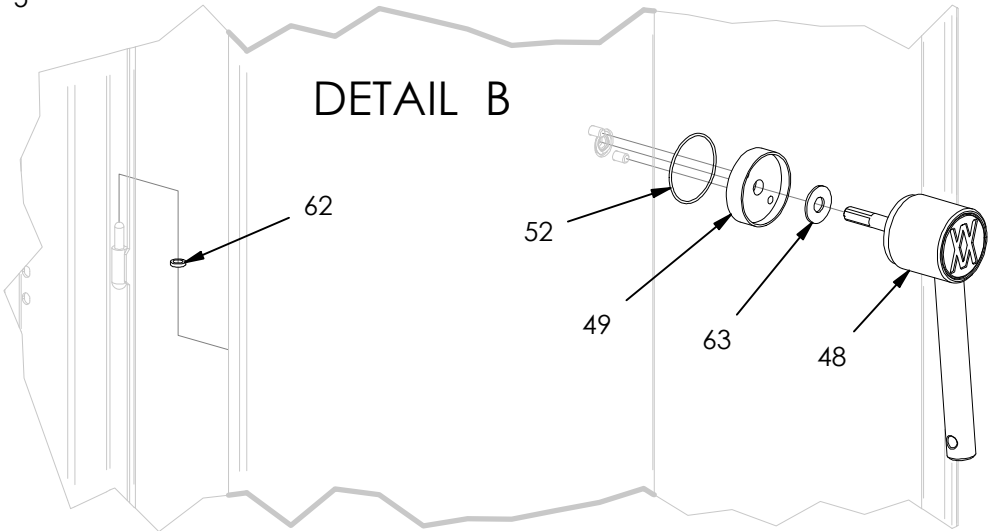
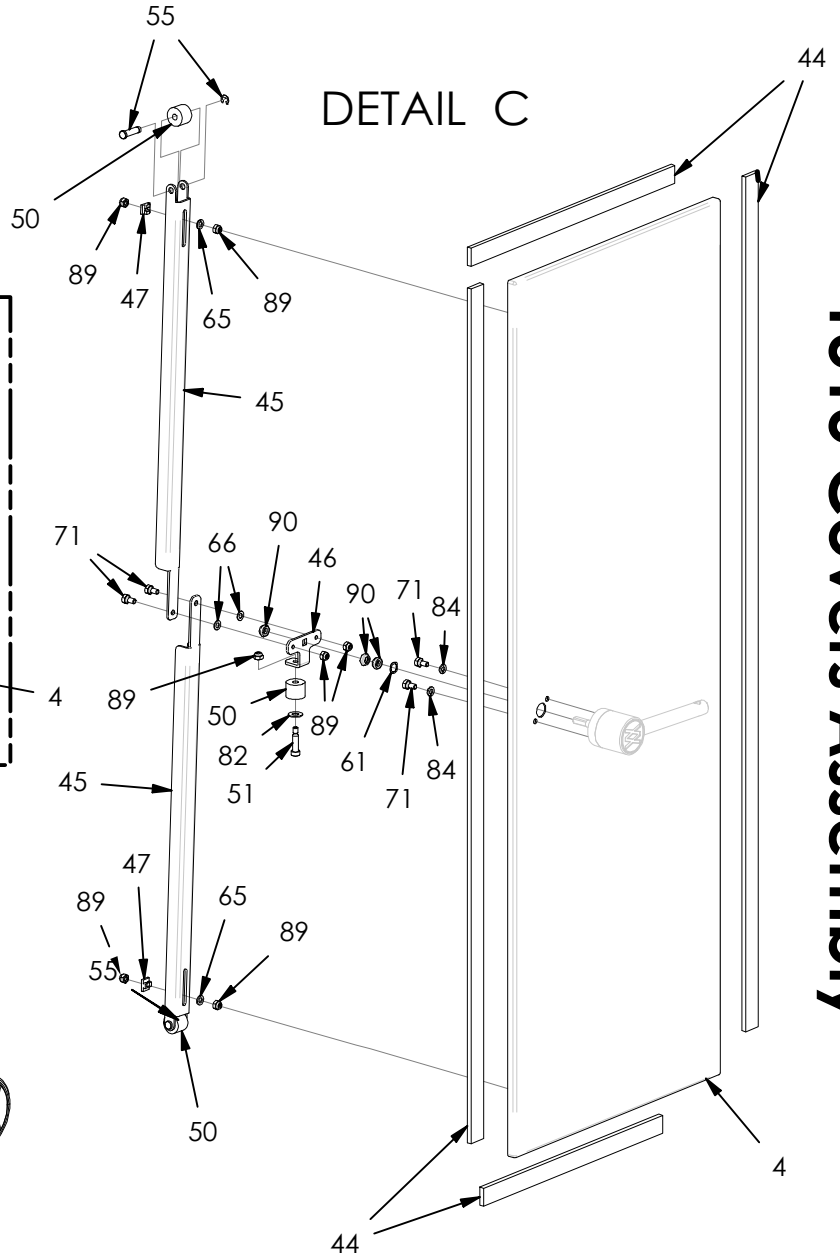
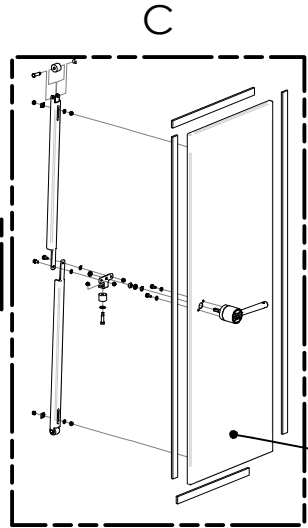
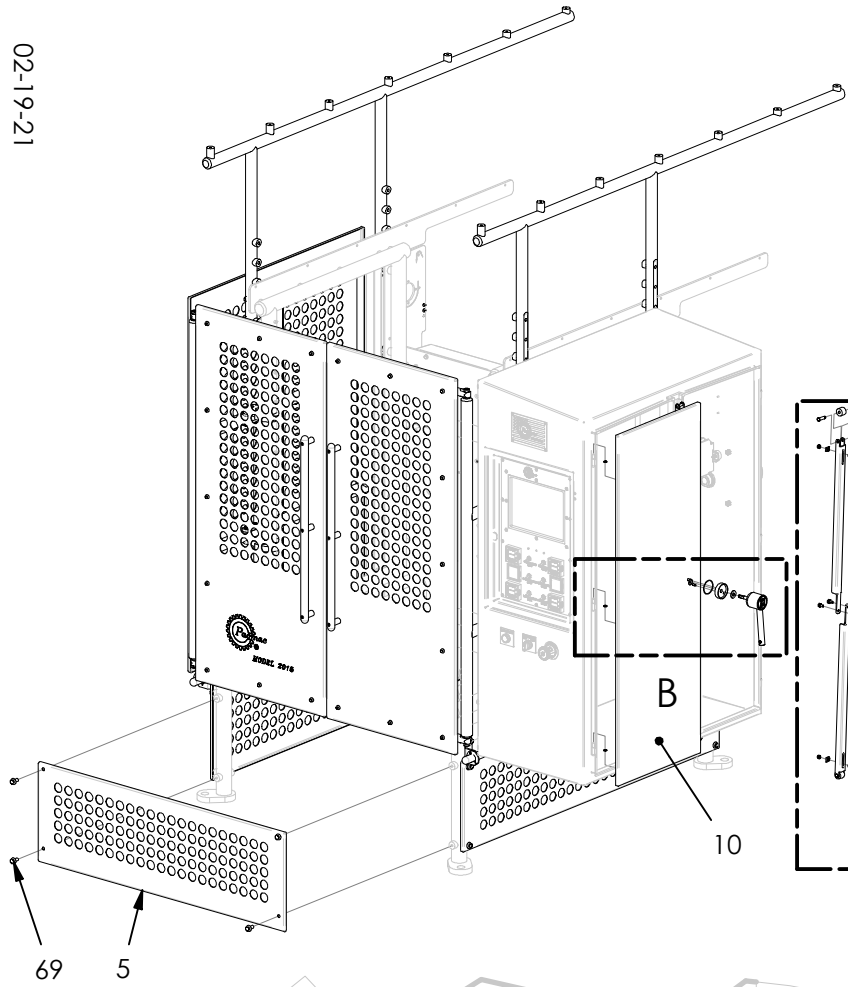


A9512-0065 Retractable Tube Stop

ITEM	PART NUMBER	DESCRIPTION	QTY
1	9512-0065	Bracket	1
2	9512-0065 -2	Air Cylinder	1
3	9512-0065 -3	Stop	1
4	9200-0062	Flat Washer	1
5	9200-0046	Tubing Connector	2
6	9512-0065 -1	Cylinder Mount	1
7	9207-0032	Handle	1
8	1/2-13X2HH	Hex Head Bolt	1
9	5/16LW	Lock Washer	1
10	1/2LW	Lock Washer	1
11	5/16-18HN	Hex Nut	1
12	7/16-20HN	Hex Nut	1
13	3/4-16HLN	Hex Low Nut	1

1515 Covers Assembly



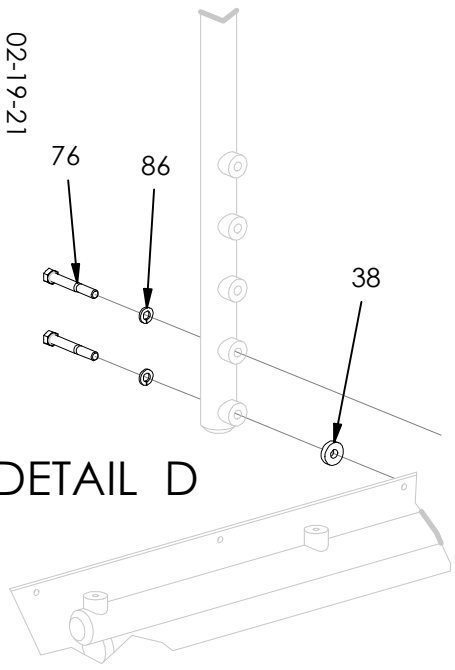


1515 Covers Assembly

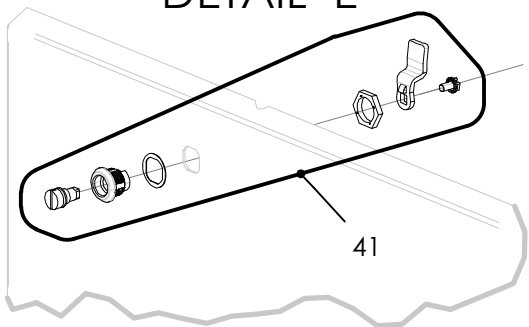
1515 Covers Assembly

02-19-21

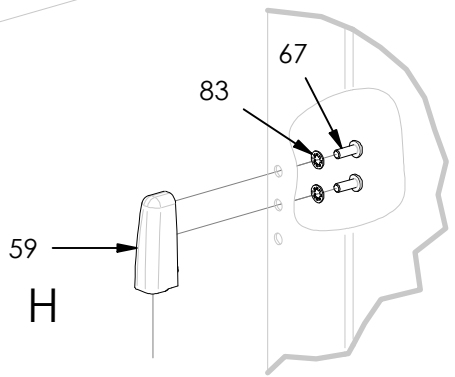
DETAIL D



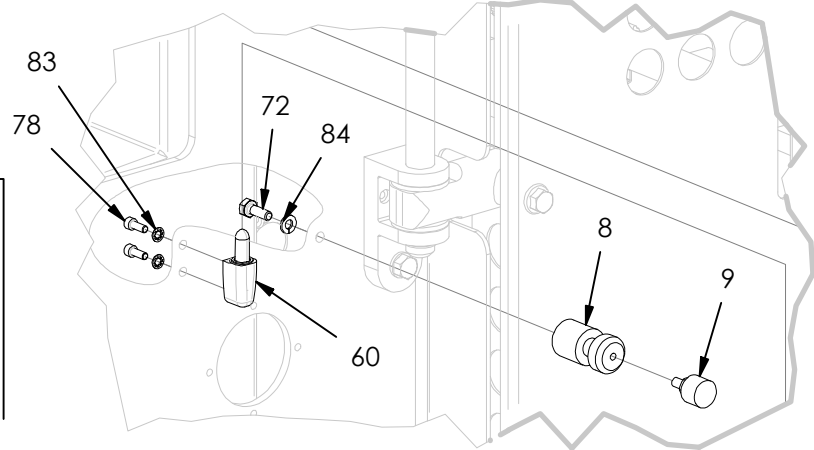
DETAIL E



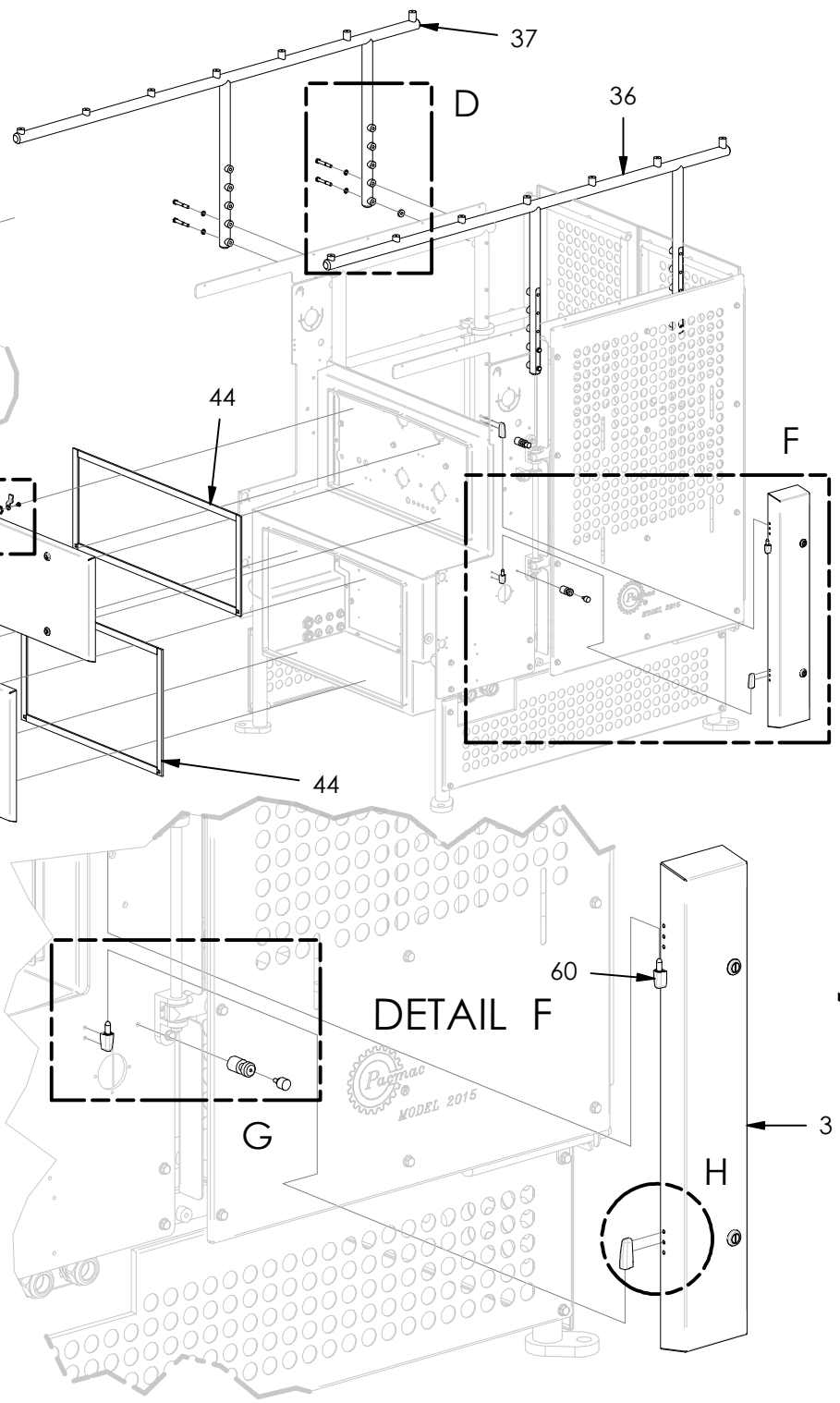
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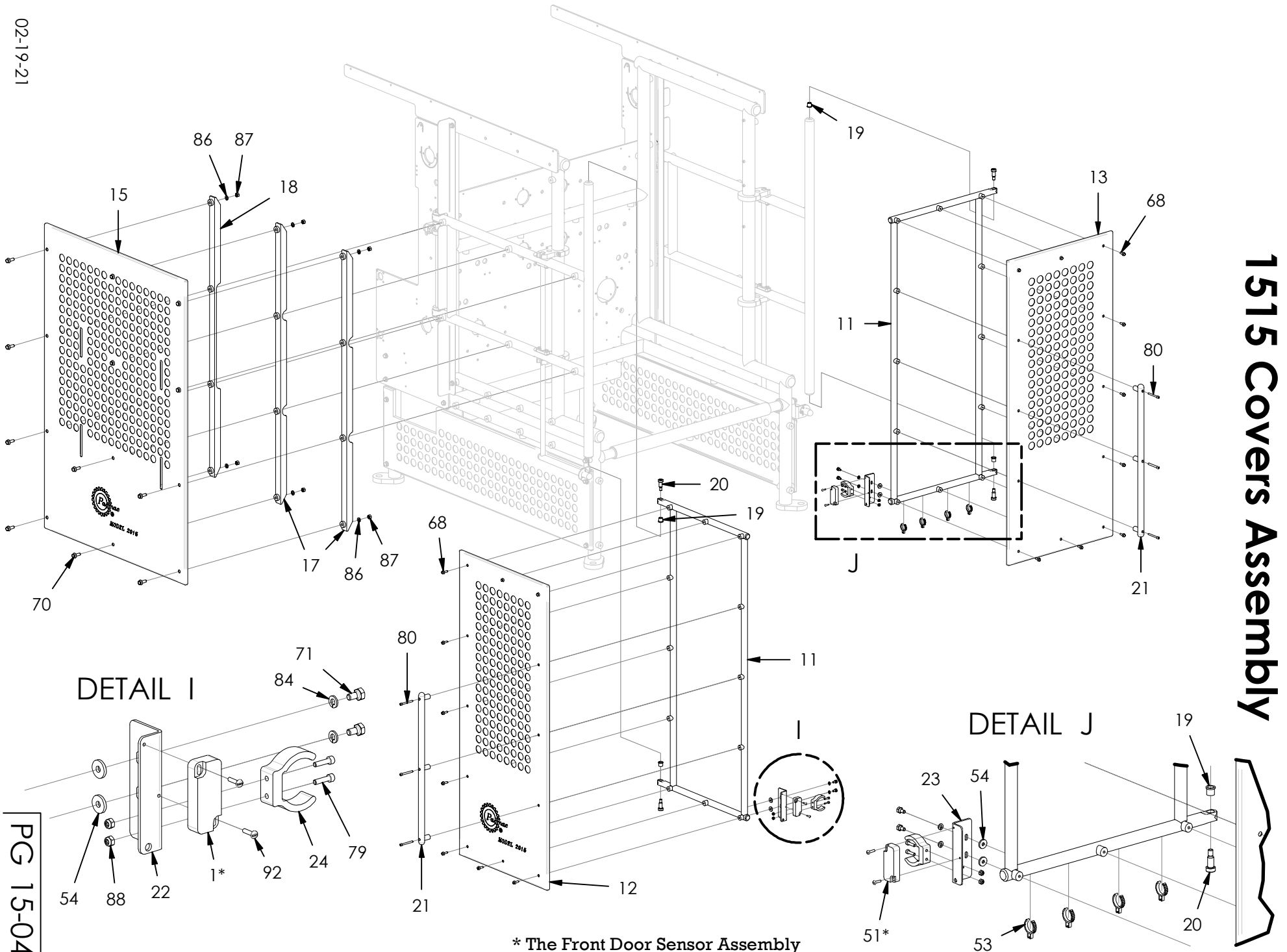


DETAIL G



DETAIL F





1515 Covers Assembly

DETAIL I

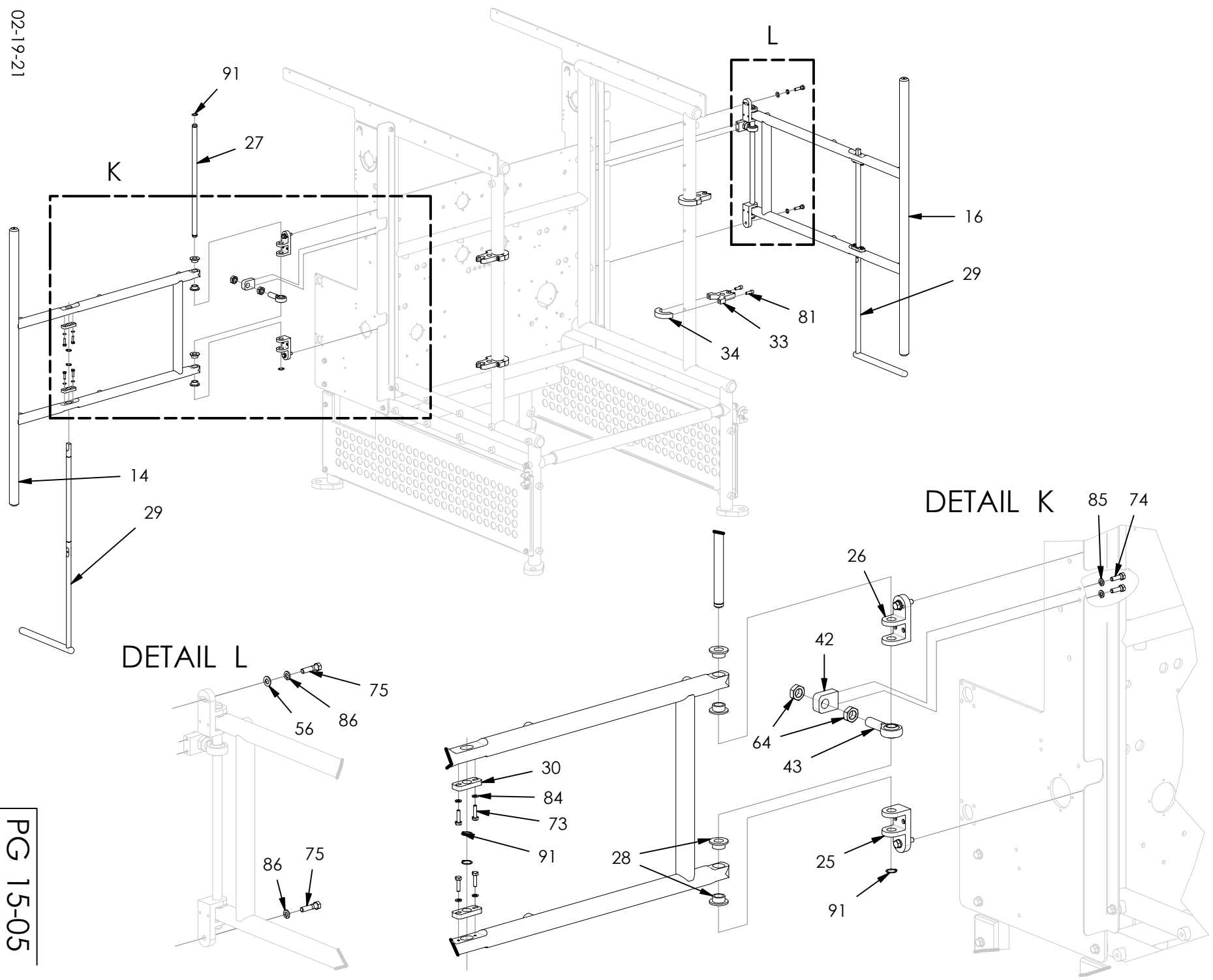
DETAIL J

PG 15-04

* The Front Door Sensor Assembly consists of two separate halves.

1515 Covers Assembly

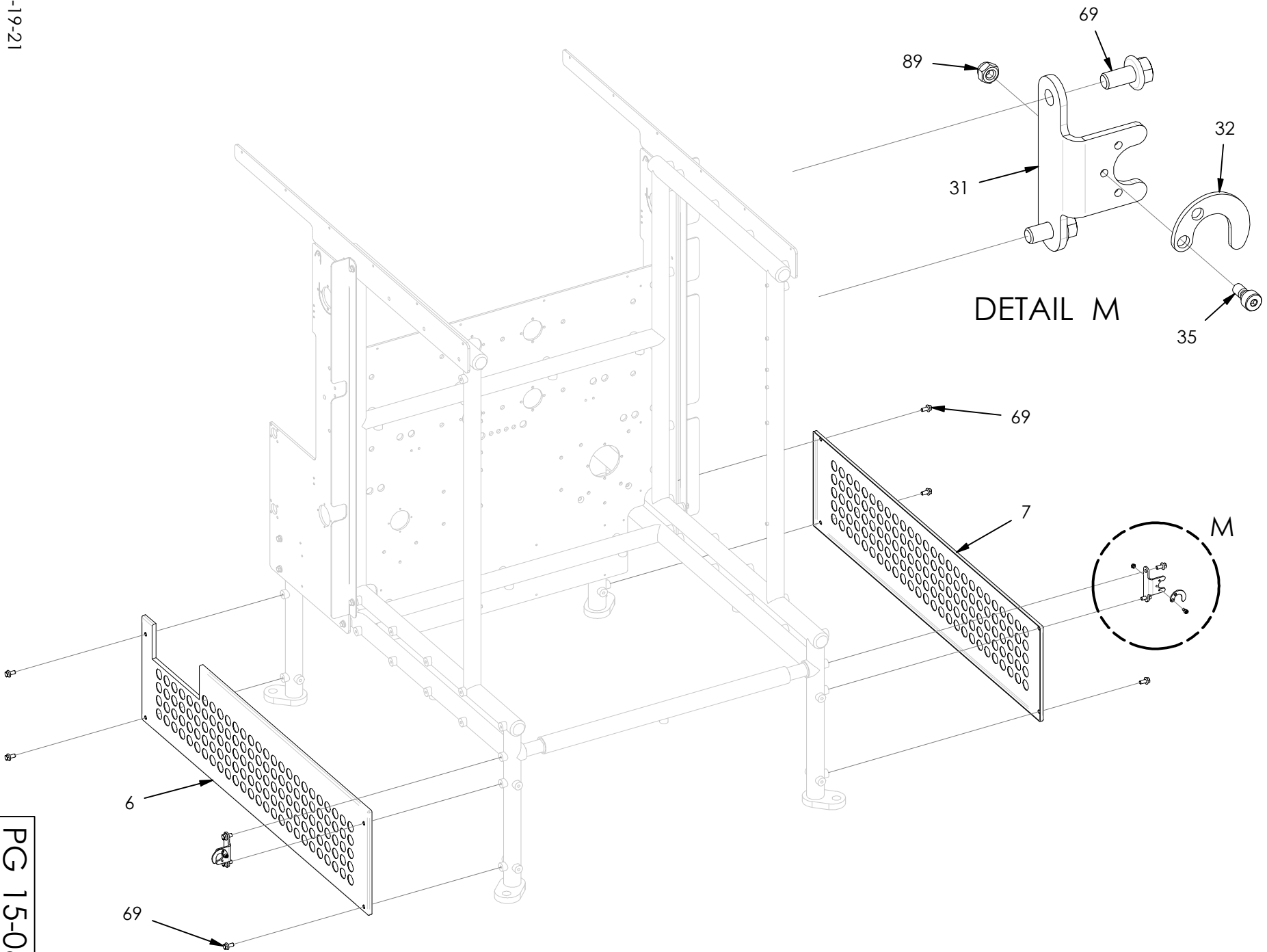
02-19-21



1515 Covers Assembly

02-19-21

PG 15-06



1515 Covers Assembly

ITEM	PART NUMBER	DESCRIPTION	QTY
1	1518-A209UL	Front Door Sensor Assy	1
2	9515-0009	RH Lexan Door Assembly	1
3	1515-0003	Guard	1
4	1515-0006	Right Door Assembly	1
5	1515-0013SS	Lower Guard, Front	1
6	1515-0014SS	Lower Guard, Left Side	1
7	1515-0015SS	Lower Guard, Right Side	1
8	1515-0019	Lock Stud	2
9	1515-0021	Threaded Bumper	2
10	1515-0054	Left Door Assembly	1
11	1515-0101	Door Frame, Front	2
12	1515-0102SSV2	Door Panel, Left Front	1
13	1515-0104SSV2	Door Panel, Right Front	1
14	1515-0105	Door Frame, Left Side	1
15	1515-0106SSV2	Door Panel, Left Side	1
16	1515-0107	Door Frame, Right Side	1
17	1515-0110	Panel Reinforcement	2
18	1515-0111	Panel Reinforcement	1
19	1515-0112	Bushing	4
20	1515-0113	Shoulder Bolt	4
21	1515-0115	Front Door Handle	2
22	1515-0116	LH Bracket	1
23	1515-0117	RH Bracket	1
24	1515-0119	Door Clasp	2
25	1515-0120	Clevis	2
26	1515-0120A	Clevis	2
27	1515-0121	Pivot Shaft	2
28	1515-0122	Bushing	8
29	1515-0123	Lock Shaft Assembly	2
30	1515-0124	Alignment Plate	4
31	1515-0125	Lock Bracket	2
32	1515-0126	Latch	2
33	1515-0127	Lock Block	4
34	1515-0128	Cap	4
35	1515-0129	Shoulder Bolt	2
36	1515-0141	Support Frame, Left Side	1
37	1515-0142	Support Frame, Right Side	1
38	1515-0147	Spacer	2
39	1515-0150 -2	Lower Cover	1
40	1515-0150V2 -1	Upper Cover	1

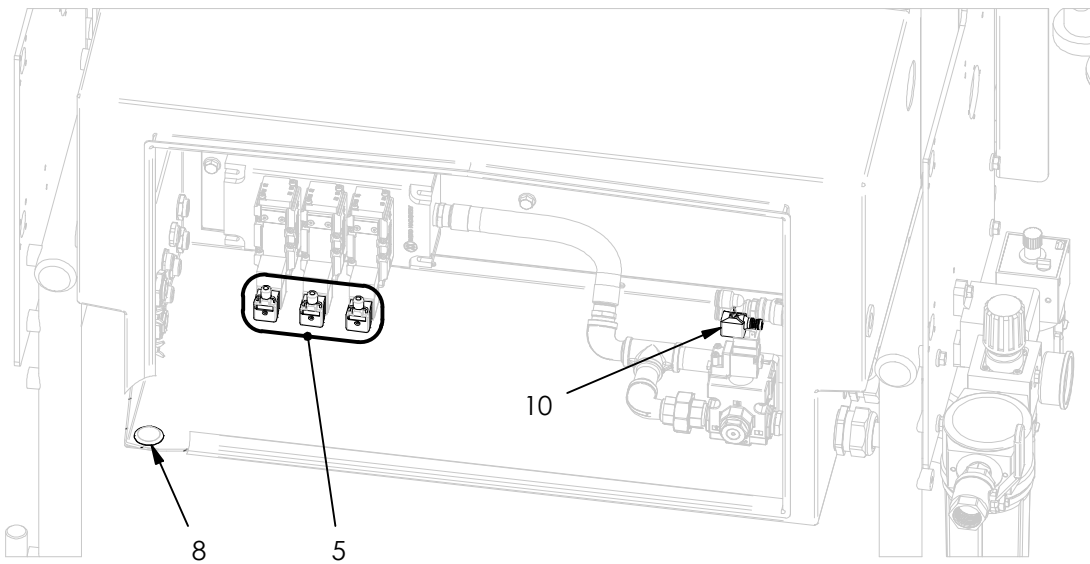
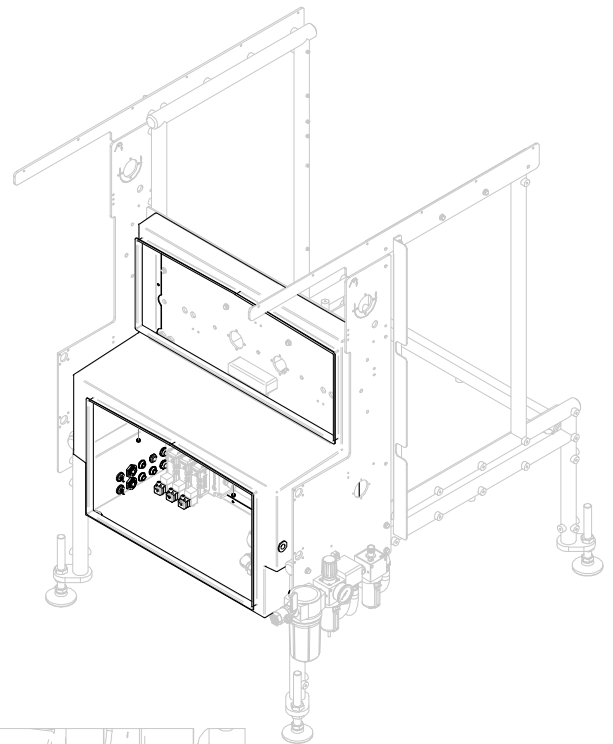
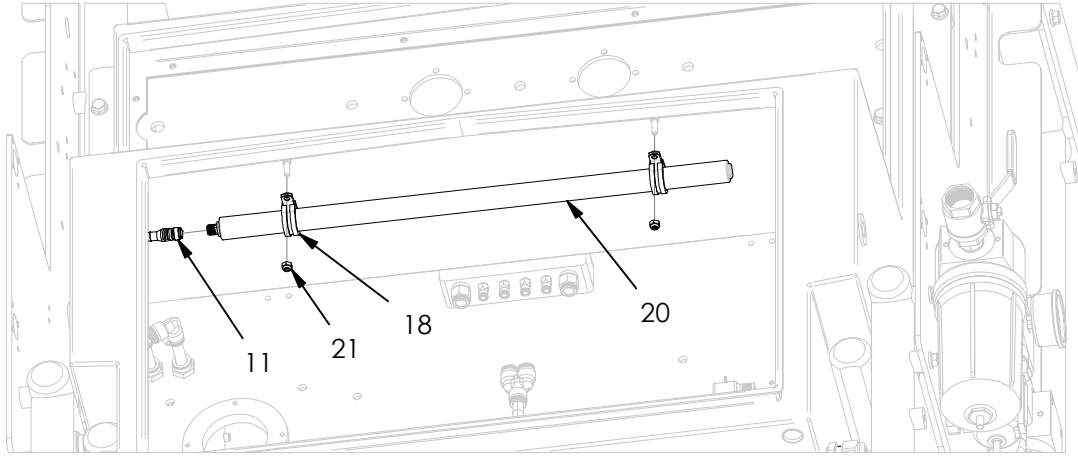
1515 Covers Assembly

ITEM	PART NUMBER	DESCRIPTION	QTY
41	1515-0152	Cam Latch Assembly	10
42	1515-0153	Base	2
43	1515-0154	Rod End	2
44	1515-0160	Silicone Strip	425"
45	1515-0200	Arm	4
46	1515-0201	Bracket	2
47	1515-0202	Bushing	4
48	1515-0203	Handle Assembly	2
49	1515-0204	Handle Mount	2
50	1515-0206	Roller	6
51	1515-0210	1/4-20 X7/16 + 5/16X7/8-Shank Shoulder Bolt	2
52	1515-0211	1/16X1.75I.D.X1.875O.D O-Ring	2
53	1518-0158	Cable Holder	4
54	9208-0016	Washer	4
55	92735A340	Clevis Pin w Retaining Rng	4
56	9500-127	Washer	2
57	9515-0032 -FEMALE	Hinge	1
58	9515-0033 -MALE	Hinge	1
59	9515-0049UL -FEMALE	Hinge	2
60	9515-0049UL -MALE	Hinge	2
61	9714K320	Wave Disc Spring	2
62	MI-0016-3	Hinge Bushing	6
63	1515-0207	3/8" Acetal Flat Washer	2
64	3/4-16BRHN	Brass Hex Nut	4
65	1515-0208	1/4" Nylon Flat Washer	4
66	1515-0209	1/4" Lubricating Shim Washer	4
67	10-32X1/2BH	Button Head Screw	4
68	1/4-20X3/4FB	Flange Bolt	18
69	3/8-16X3/4FB	Flange Bolt	14
70	3/8-16X1FB	Flange Bolt	12
71	1/4-20X1/2HH	Hex Head Bolt	12
72	1/4-20X3/4HH	Hex Head Bolt	2
73	1/4-20X1HH	Hex Head Bolt	8
74	5/16-18X1HH	Hex Head Bolt	4
75	3/8-16X1 1/2HH	Hex Head Bolt	4
76	3/8-16X2 3/4HH	Hex Head Bolt	8
77	10-24X3/8SH	Socket Head Bolt	4
78	10-32X1/2SH	Socket Head Bolt	4
79	10-32X3/4SH	Socket Head Bolt	4
80	1/4-20X2 1/4SH	Socket Head Bolt	6

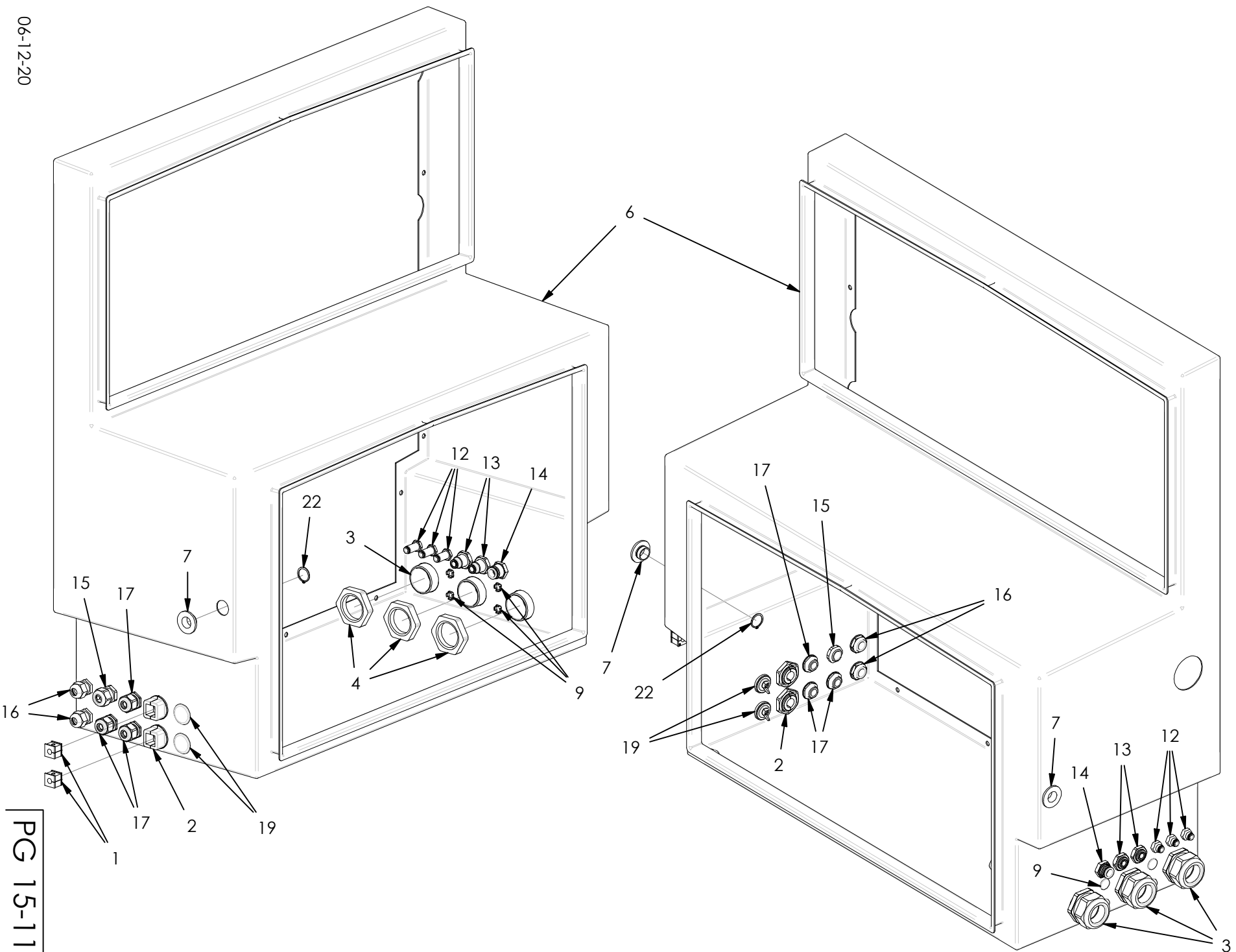
1515 Covers Assembly

ITEM	PART NUMBER	DESCRIPTION	QTY
81	3/8-16X1SH	Socket Head Bolt	8
82	5/16FW	Flat Washer	2
83	#10LWIT	Internal Tooth Lock Washer	12
84	1/4LW	Lock Washer	18
85	5/16LW	Lock Washer	4
86	3/8LW	Lock Washer	18
87	3/8-16HN	Hex Nut	6
88	10-32LN	Lock Nut	4
89	1/4-20LN	Lock Nut	16
90	3/8-16LLN	Low Lock Nut	6
91	3/4EXT	Snap Ring	8
92	M4X16TRBH	Tamper-Resistant Button Head	4

A1515-0150 Rear Enclosure Sub-Assembly



A1515-0150 Rear Enclosure Sub-Assembly



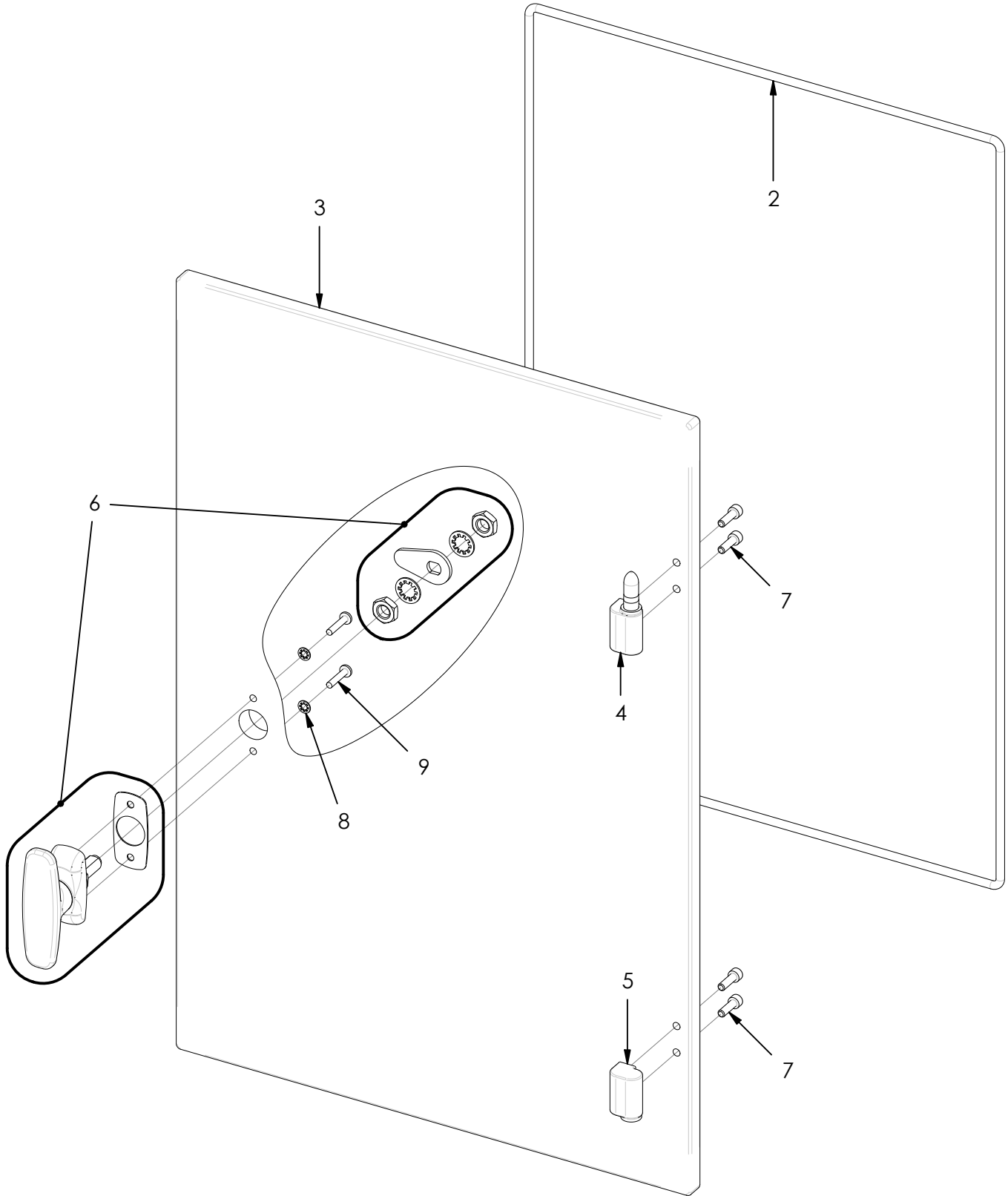
06-12-20

PG 15-11

A1515-0150 Rear Enclosure Sub-Assembly

ITEM	PART NUMBER	DESCRIPTION	QTY
1	1500-0205 -9	Grommet	2
2	1500-0205X1	Cord Grip	2
3	1500-201	Cord Grip	3
4	1500-201 -1	Stainless Steel Locknut	3
5	1500-A002	Cooler Valve Cable Kit	1
6	1515-0150V2	Rear Enclosure	1
7	1515-0151	Bushing	2
8	1515-0155	Plug	2
9	1515-0164	Plug	4
10	1517-0002-2	Canfield connector	1
11	1518-0087	Rear Work Light Cable	0
12	9216-0033	Fitting, Bulkhead	3
13	9216-0035	Fitting, Bulkhead	2
14	9216-0039	Bulkhead Fitting	1
15	9500-111	Cord Grip	1
16	9500-81	Cord Grip	2
17	9516-0032	Cord Grip	3
18	9516-0090	Loom Clamp	2
19	9516-0092SS	Plug	2
20	9518-0087	2' Work Light	1
21	1/4-20LN	Lock Nut	2
22	7/8EXT	Snap Ring	2

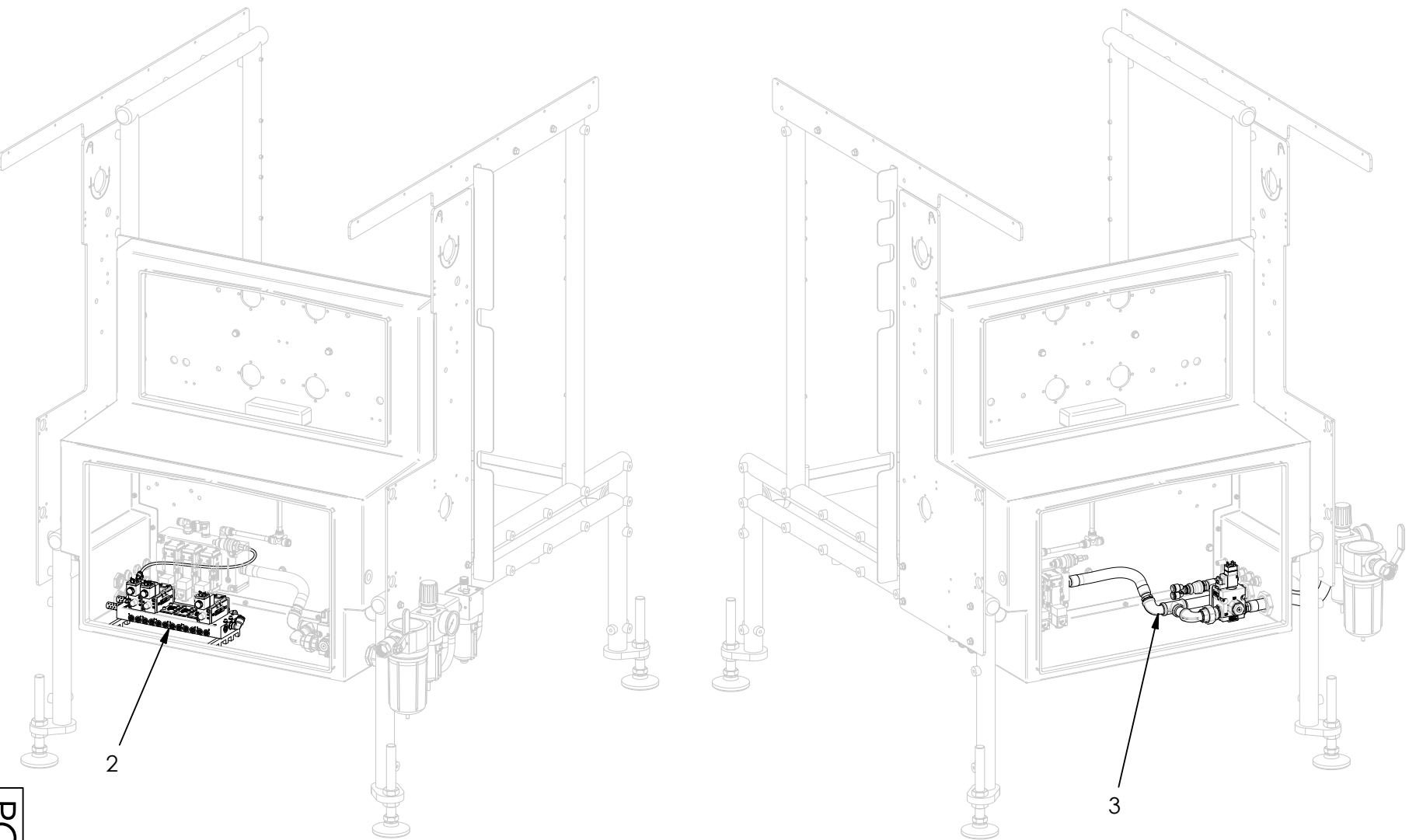
9515-0009 RH Lexan Door Assembly



9515-0009 RH Lexan Door Assembly

ITEM	PART NUMBER	DESCRIPTION	QTY
1	95W513	Door Pawl	1
2	8605K42	Round Gasket	1
3	9515-0009UL -1	Operator Door	1
4	9515-0032 -MALE	Hinge	1
5	9515-0033 -FEMALE	Hinge	1
6	9515-0035	Handle, Door	1
7	10-24X5/8SH	Socket Head Bolt	4
8	#8LWTT	Internal Tooth Lock Washer	2
9	M4X20PPH	Phillips Pan Head Screw	2

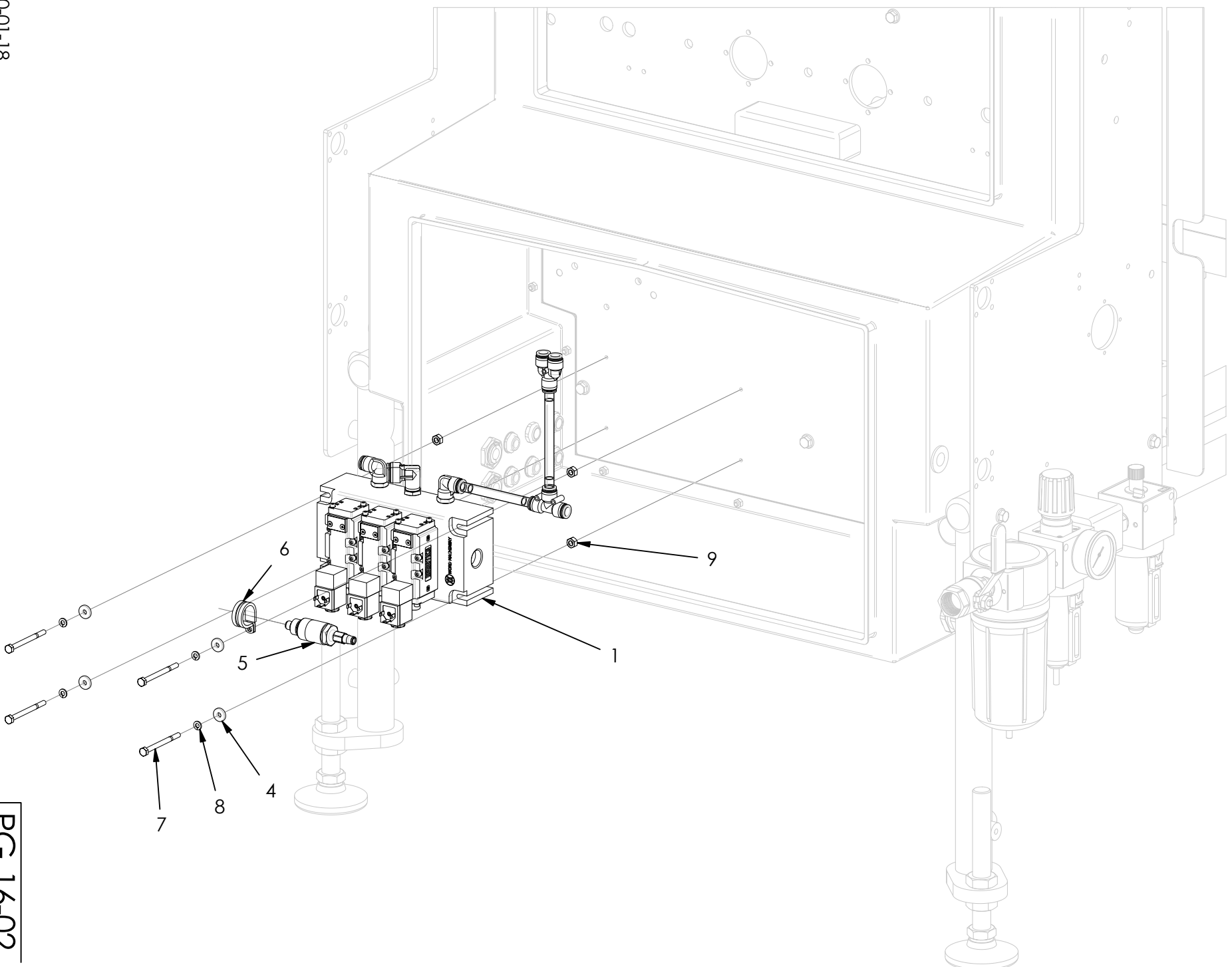
1516 Air Stack Assembly



10-01-18

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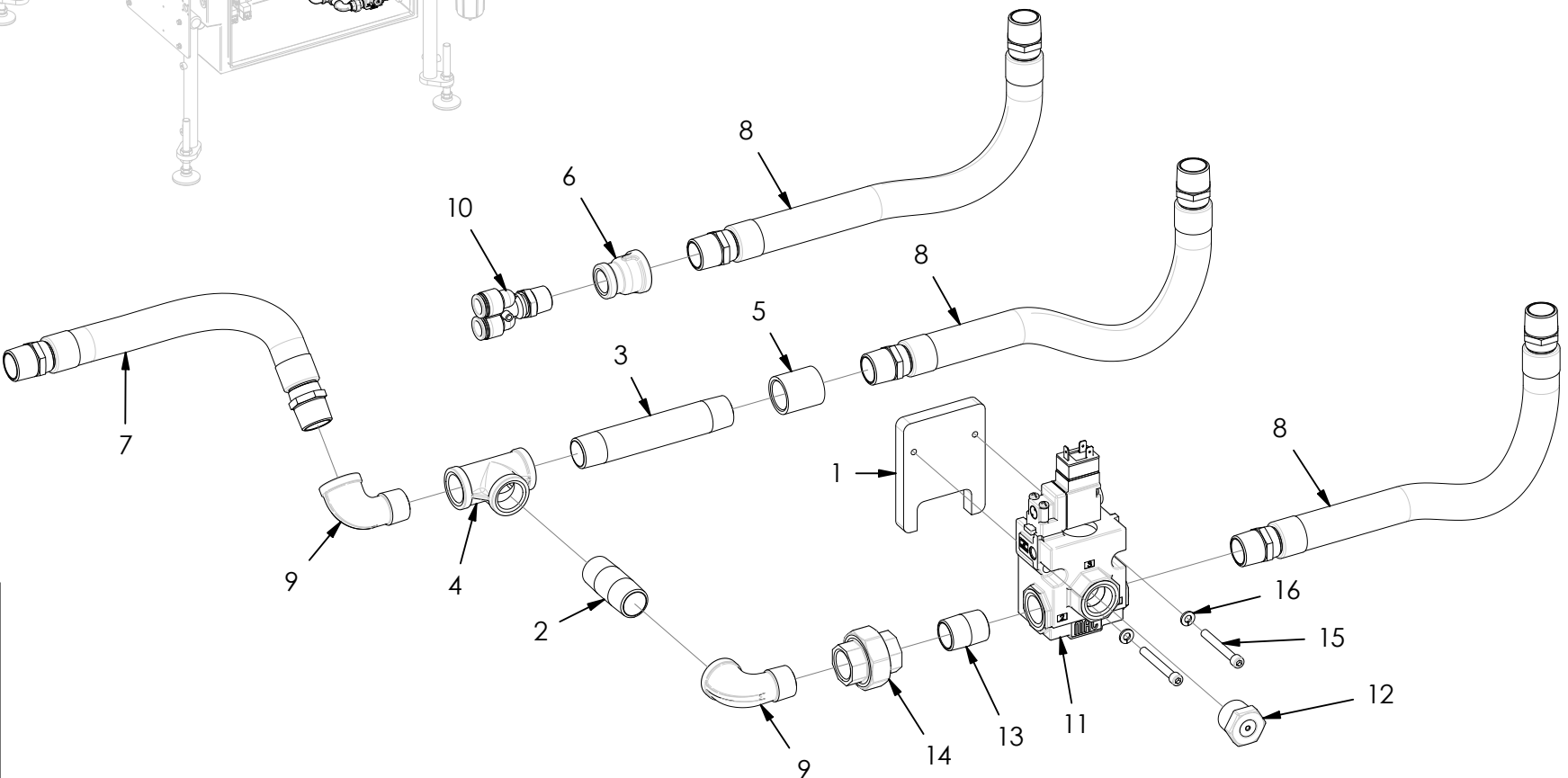
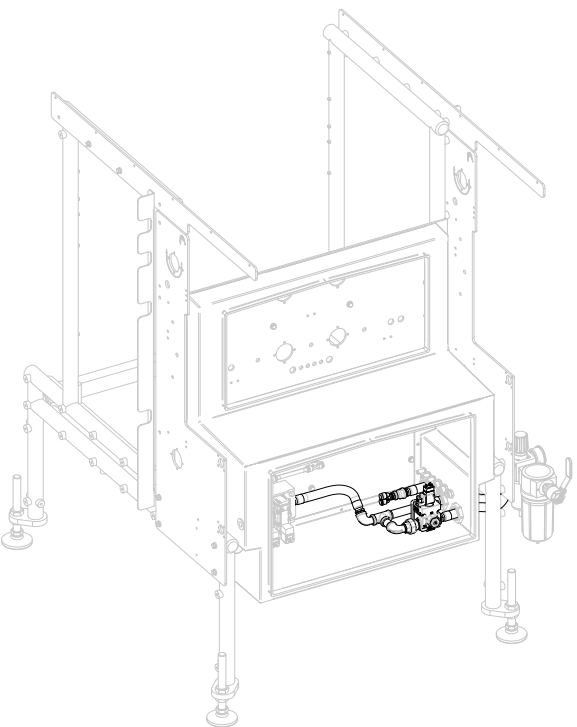
1516 Air Stack Assembly



1516 Air Stack Assembly

ITEM	PART NUMBER	DESCRIPTION	QTY
1	1516	Cooler Air Valve Assembly	1
2	1516-A001	Air Valve Assembly	1
3	A1500	Air Supply Assembly	1
4	9208-0016	Washer	4
5	9216-0007	Pressure Switch Assembly	1
6	9516-0090	Loom Clamp	1
7	1/4-20X3 1/4HH	Hex Head Bolt	4
8	1/4LW	Lock Washer	4
9	5/16-18HN	Hex Nut	4

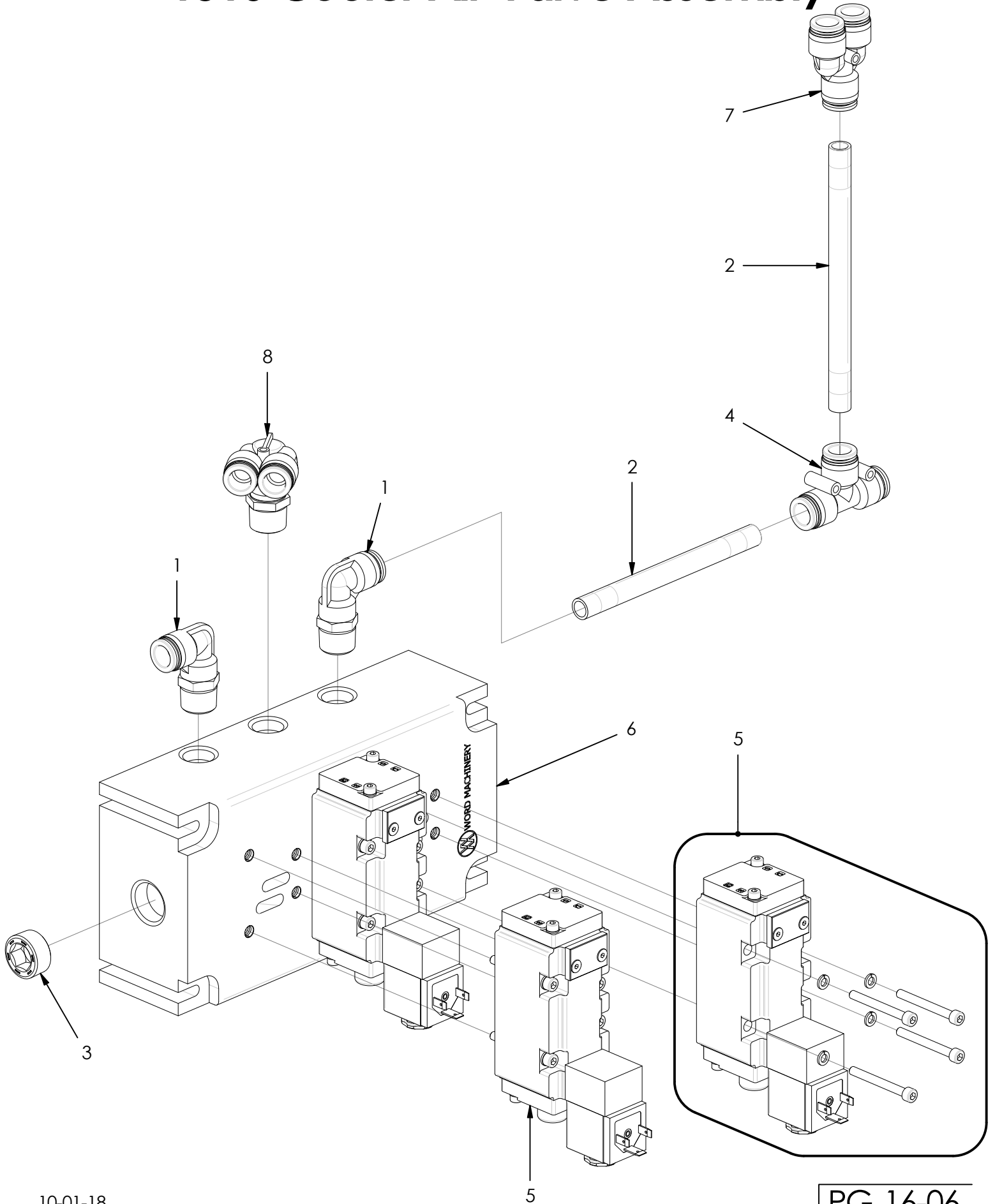
A1500 Air Supply Assembly



A1500 Air Supply Assembly

ITEM	PART NUMBER	DESCRIPTION	QTY
1	1516-0102	Spacer	1
2	1516-0120	3/4 x 2.5 Nipple	1
3	1516-0121	3/4 x 5.5 Nipple	1
4	1516-0122	3/4" Tee	1
5	1516-0123	3/4" Coupling	1
6	1516-0124	3/4 x 1/2 Reducer Coupling	1
7	1517-0039 -13	13" Hose Assembly	1
8	1517-0039 -16	16" Hose Assembly	3
9	9516-0020SS	Street Elbow	2
10	9516-0062	Connector, Tubing	1
11	9517-0006	MAC Valve	1
12	9517-0036 -1	Relief Plug Assembly	1
13	9517-0037	3/4" Nipple	1
14	9517-0038SS	3/4" Union	1
15	1/4-20X2SH	Socket Head Bolt	2
16	1/4LW	Lock Washer	2

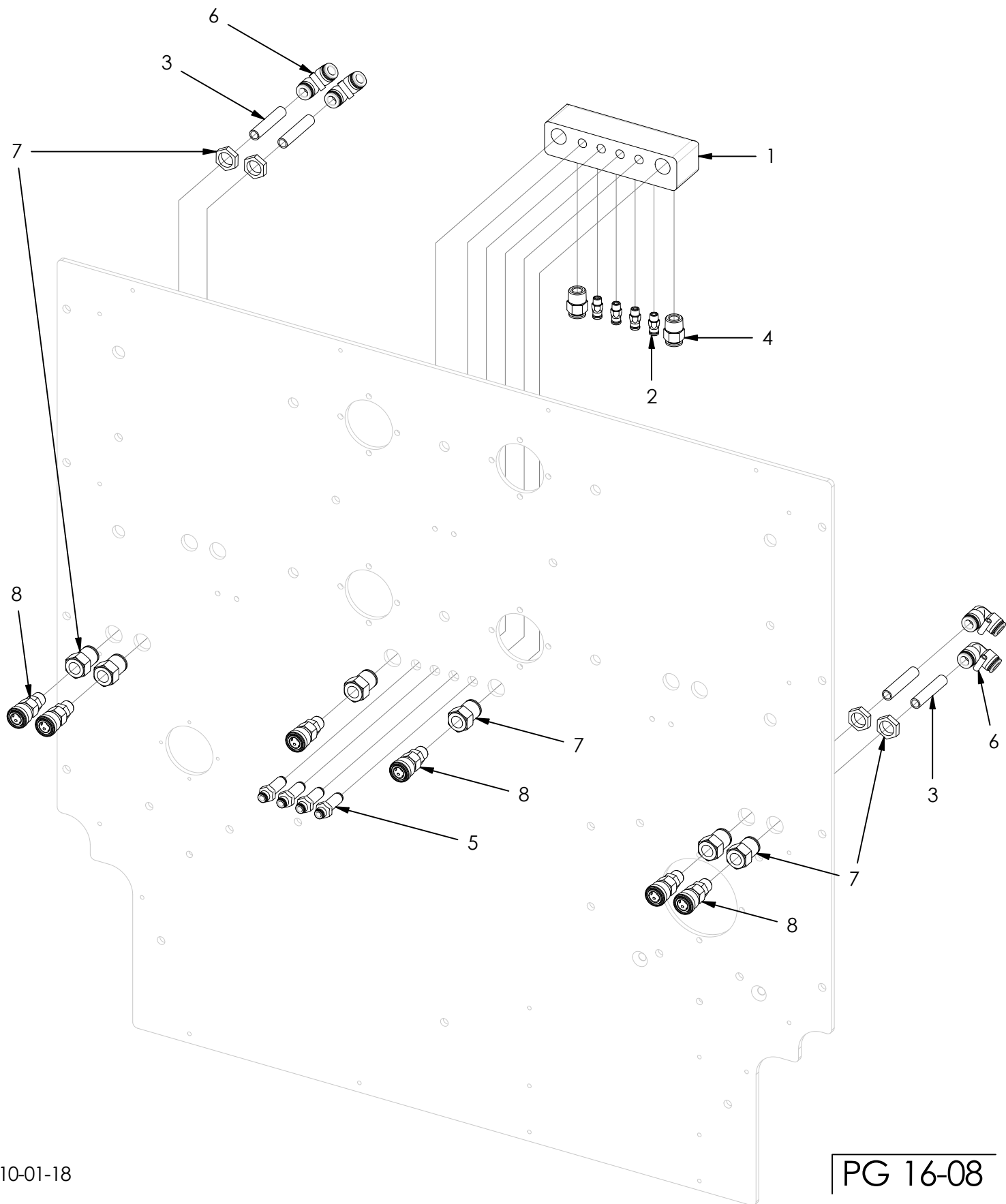
1516 Cooler Air Valve Assembly



1516 Cooler Air Valve Assembly

ITEM	PART NUMBER	DESCRIPTION	QTY
1	9200-0058	Tubing Connector	2
2	9200-0060BPU	1/2" Blue PU Air Tubing	1'
3	9216-0011	3/4" Pipe Plug	1
4	9216-0034	1/2" Union Tee	1
5	9516-0030NM	Valve Body	3
6	9516-0031RX -3	Three Station Manifold	1
7	9516-0035	1/2" Union "Y"	1
8	9516-0061	Tubing Connector	1

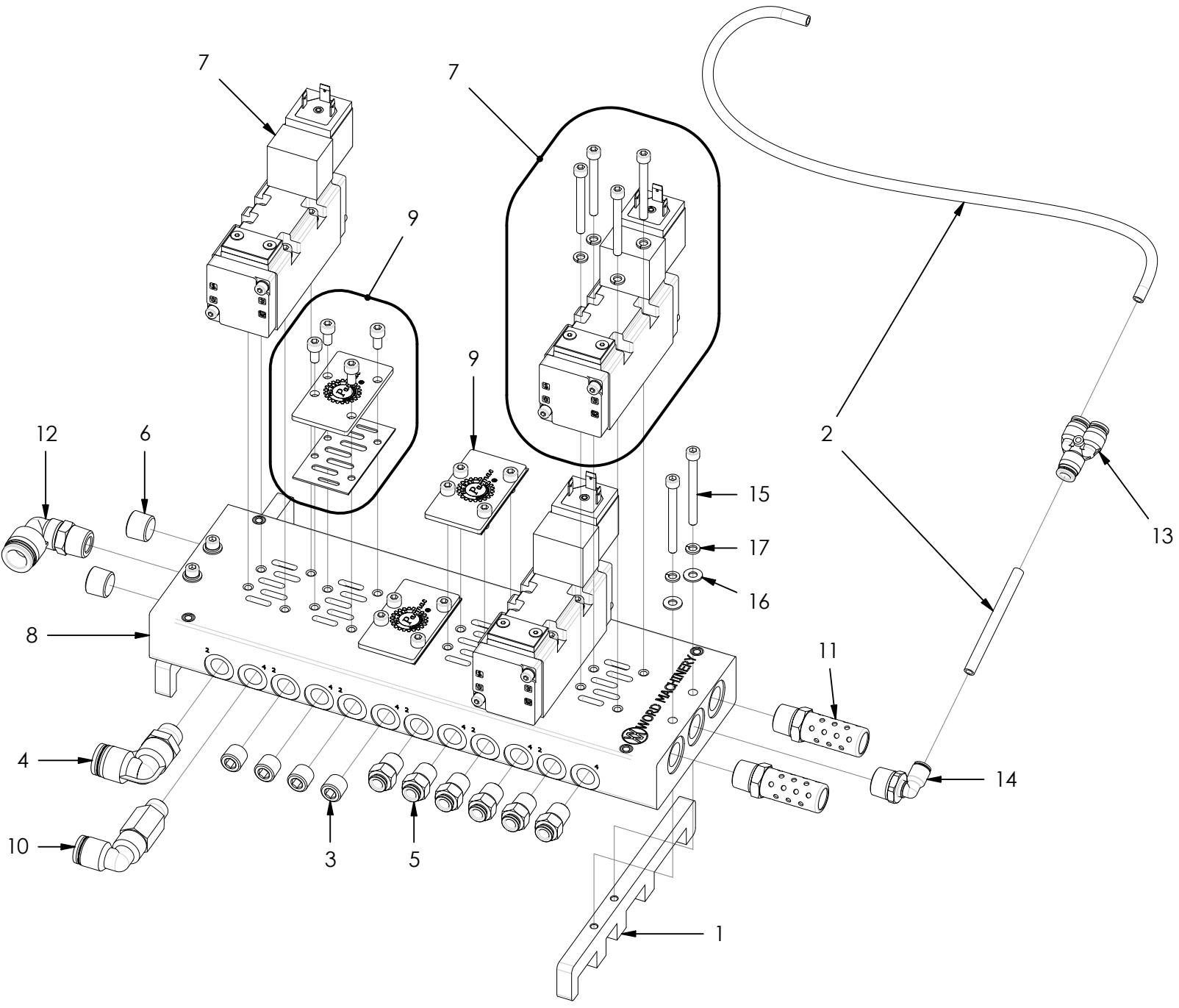
A1516-0039M Manifold Assembly



A1516-0039M Manifold Assembly

ITEM	PART NUMBER	DESCRIPTION	QTY
1	1516-0039M	Bulkhead Manifold	1
2	9200-0034	Tubing Connector	4
3	9200-0060BPU	1/2" Blue PU Air Tubing (2.500" Length)	4
4	9200-0077	Tubing Connector	2
5	9216-0033	Bulkhead Fitting	4
6	9216-0036	Tubing Connector	4
7	9516-0039	1/2" Bulkhead Female	6
8	9516-0051	Female Quick Disconnect	6

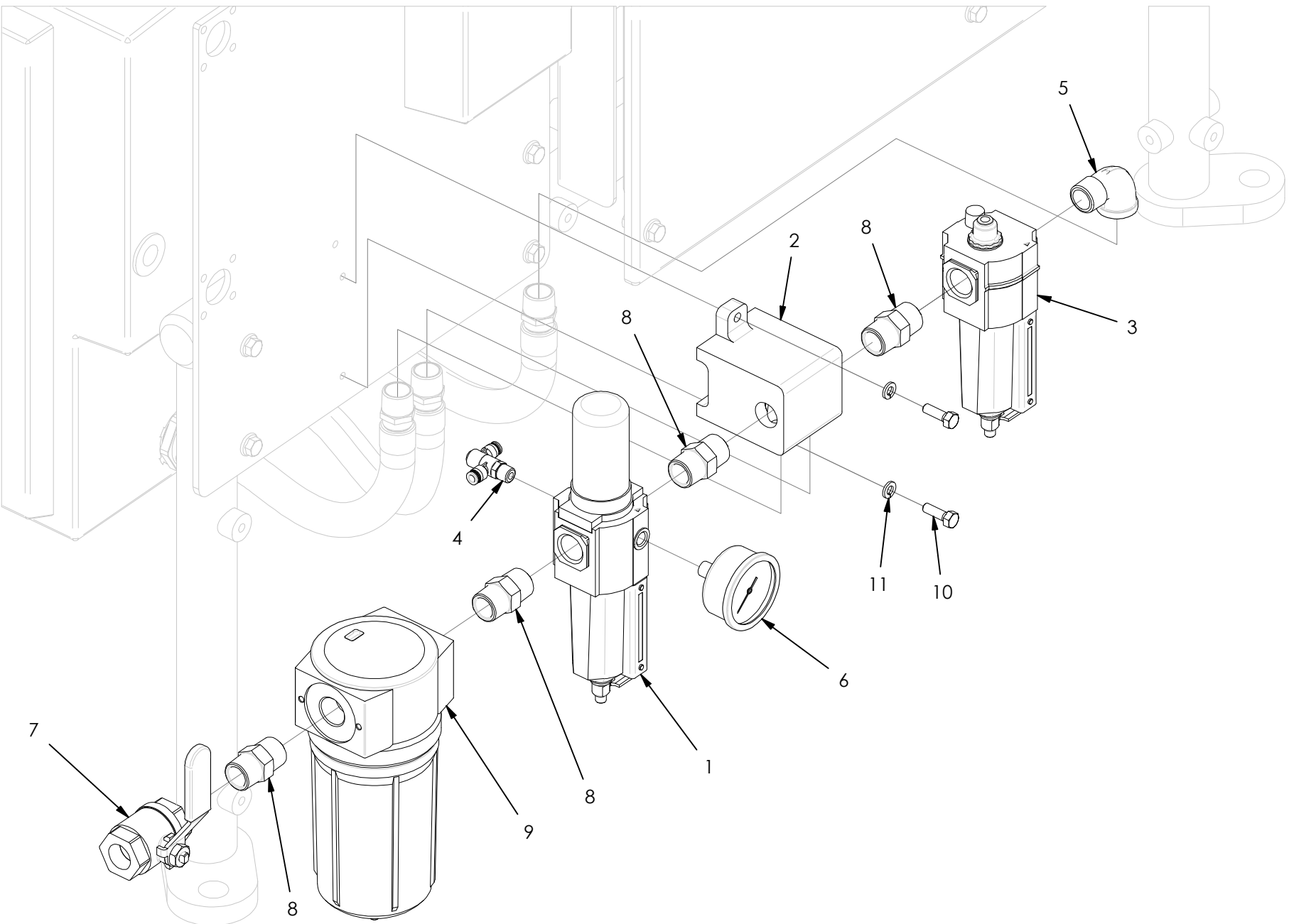
1516-A001 Air Valve Assembly



1516-A001 Air Valve Assembly

ITEM	PART NUMBER	DESCRIPTION	QTY
1	1516-0101	Spacer	2
2	9200-0039BPU	1/4" Blue PU Air Tubing	2
3	9200-0085SS	1/4" Pipe Plug	16
4	9202-0027	Tubing Connector	1
5	9216-0016	Tubing Connector	6
6	9216-0047SS	3/8" Pipe Plug	2
7	9500-77NM	Valve Body - Numatics	3
8	9500-82RX -6	Six Station Manifold	1
9	9500-85	Stainless Blanking Station	3
10	9502-0004	Tubing Connector	1
11	9517-0011	Exhaust Muffler	2
12	9547-0029	Tubing Connector	1
13	9553-0023	Y Connector	1
14	9591-0023	Tubing Connector	1
15	10-32X2SH	Socket Head Bolt	4
16	#10FW	Flat Washer	4
17	#10LW	Lock Washer	4

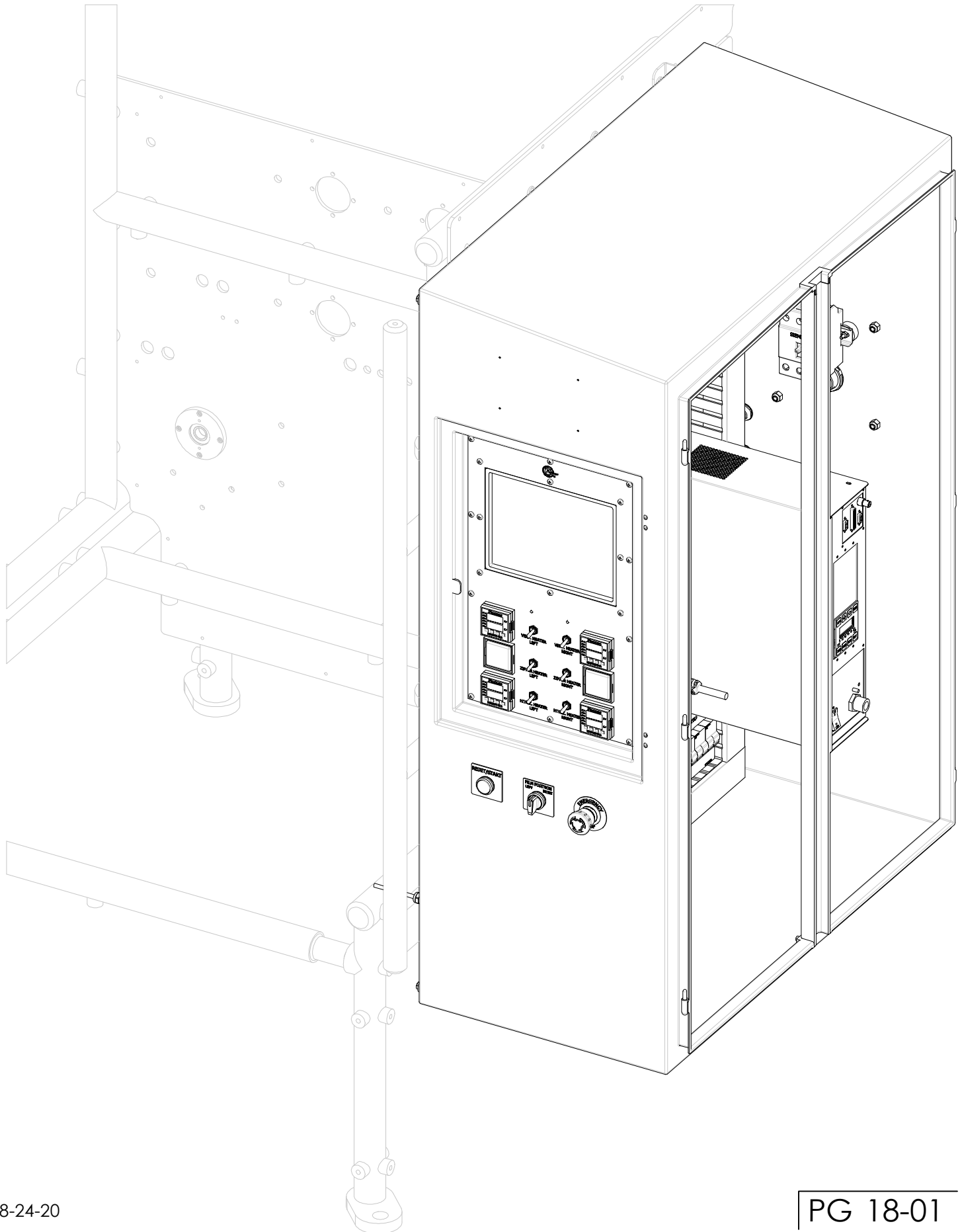
1517 Air Control Assembly



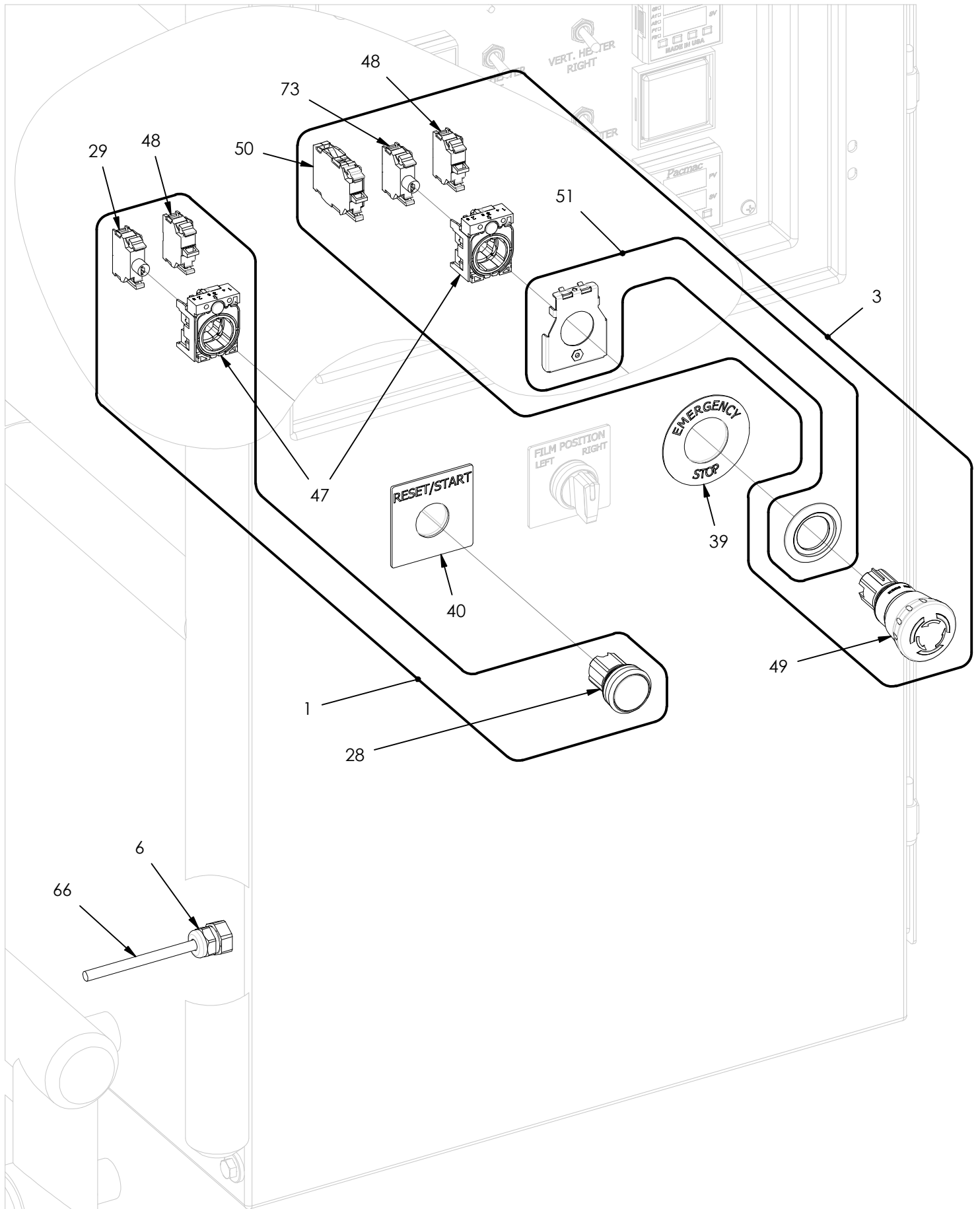
1517 Air Control Assembly

ITEM	PART NUMBER	DESCRIPTION	QTY
1	1517-0029	Filter Regulator Combo	1
2	1517-0030	Diverter Block	1
3	1517-0031	Lubricator	1
4	9502-0095	Connector, Tubing	1
5	9516-0020SS	Street Elbow	1
6	9517-0013	Gauge	1
7	9517-0026SSRV	Ball Valve	1
8	9517-0027	Nipple, Hex	4
9	9517-0028N	Water Separator	1
10	5/16-18X1HH	Hex Head Bolt	2
11	5/16LW	Lock Washer	2

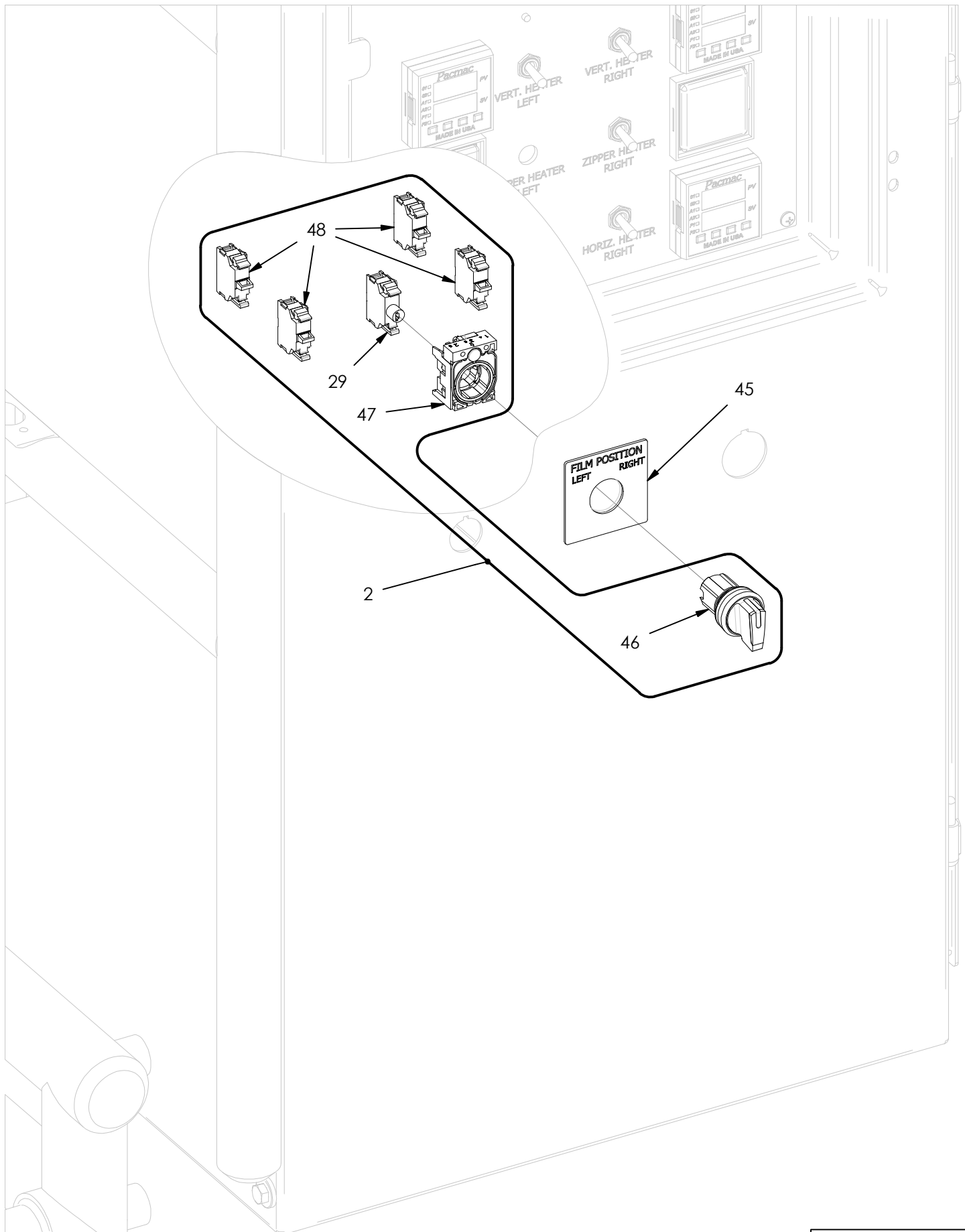
1518 Electrical Cabinet Assembly



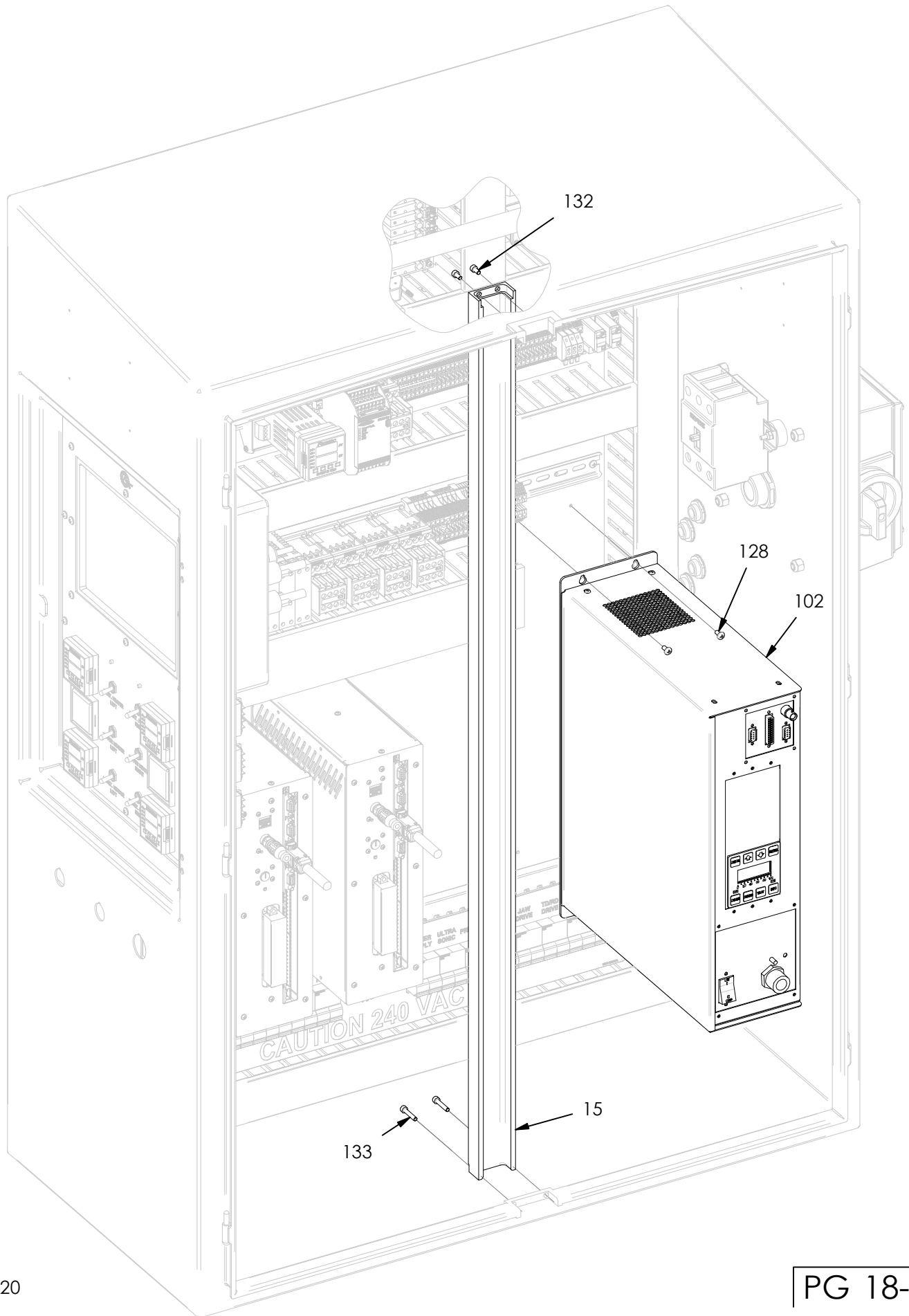
1518 Electrical Cabinet Assembly



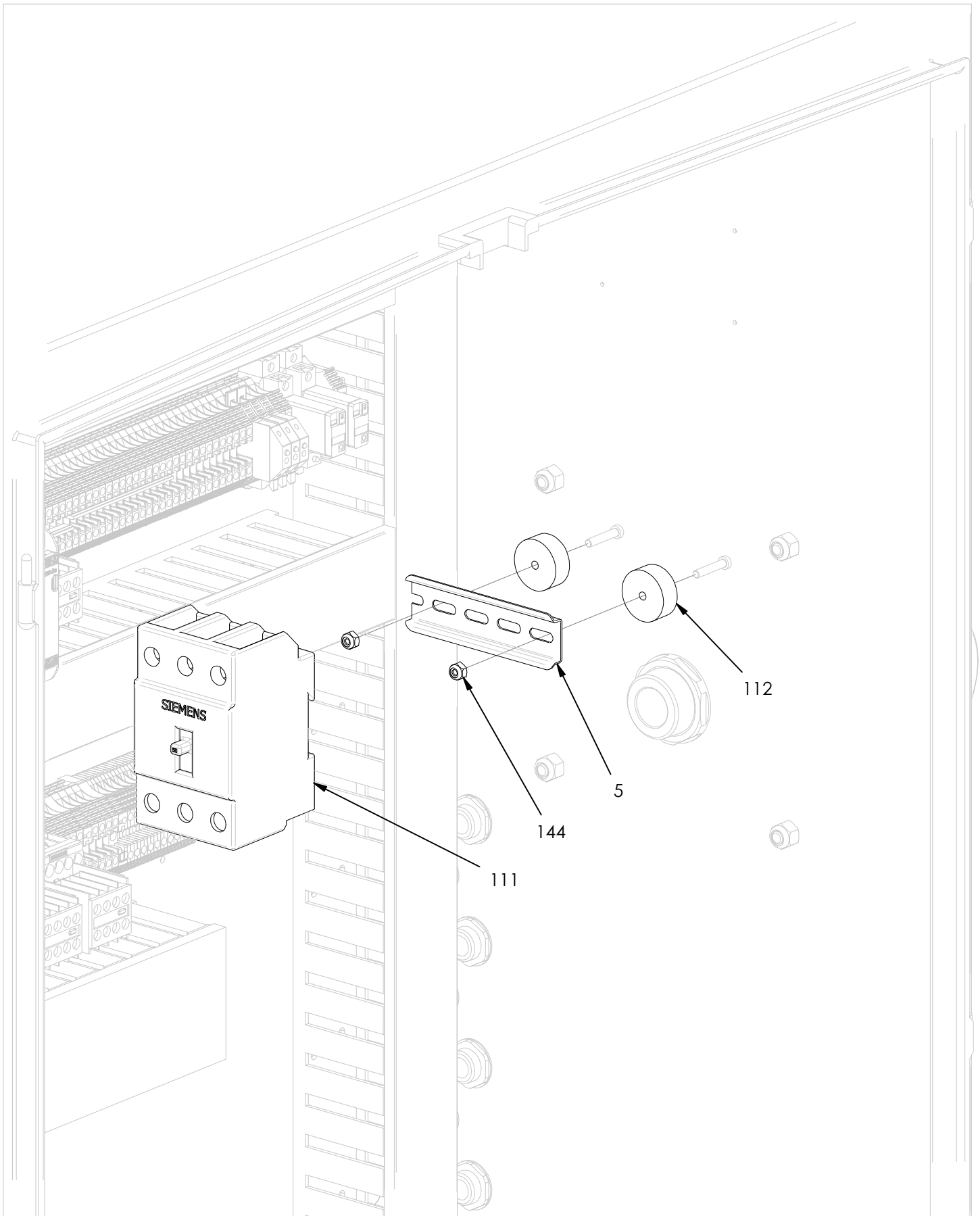
1518 Electrical Cabinet Assembly



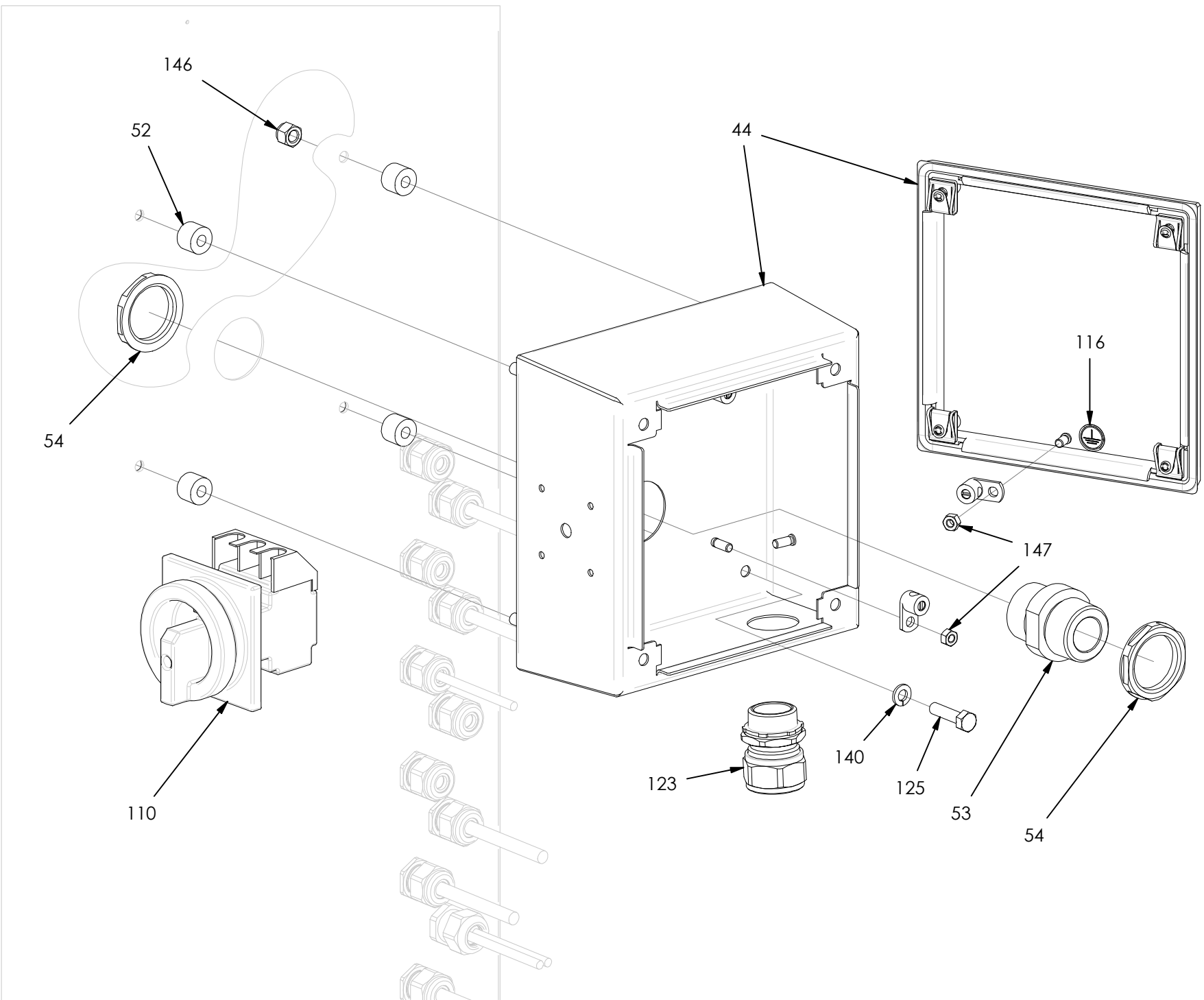
1518 Electrical Cabinet Assembly



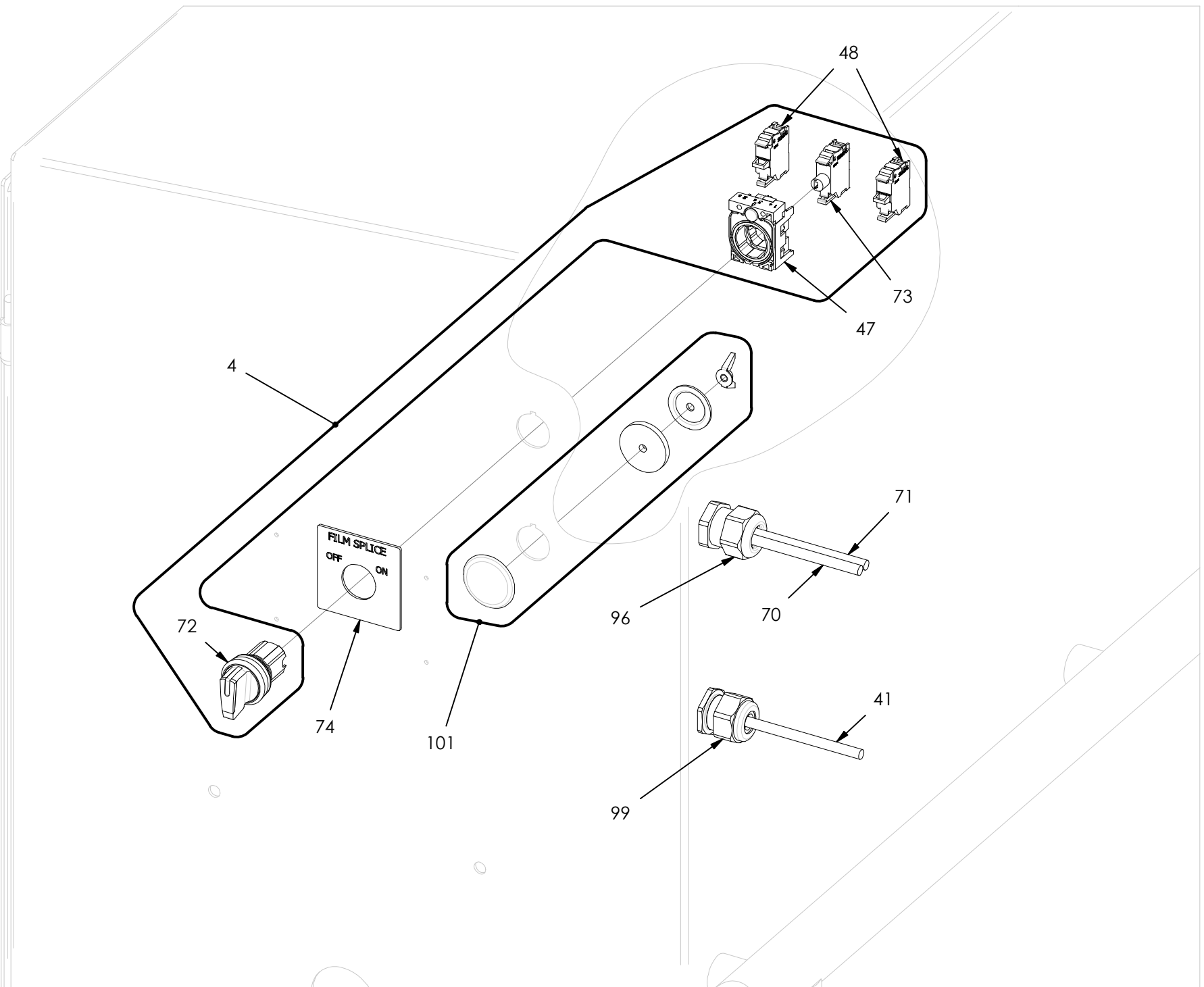
1518 Electrical Cabinet Assembly



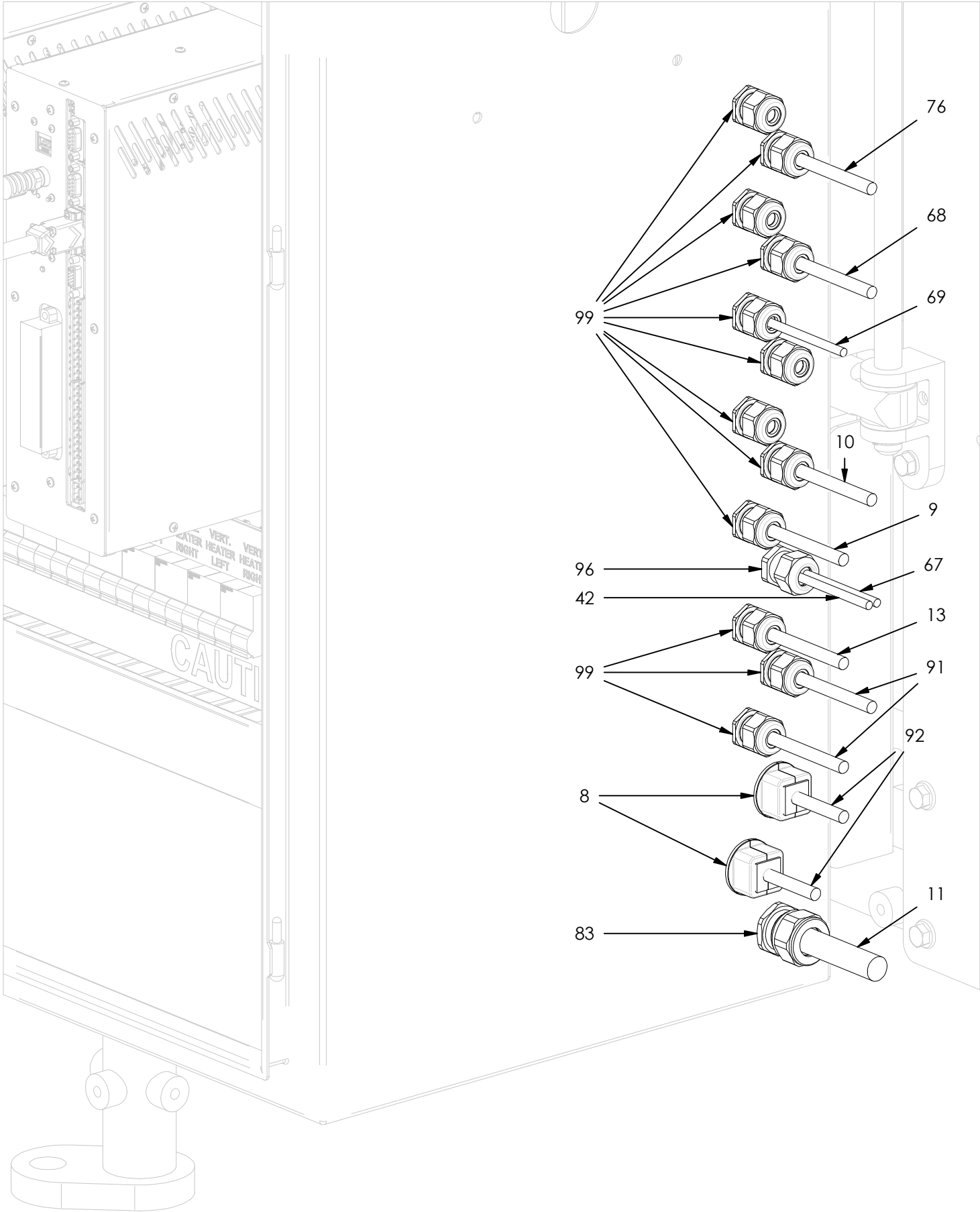
1518 Electrical Cabinet Assembly



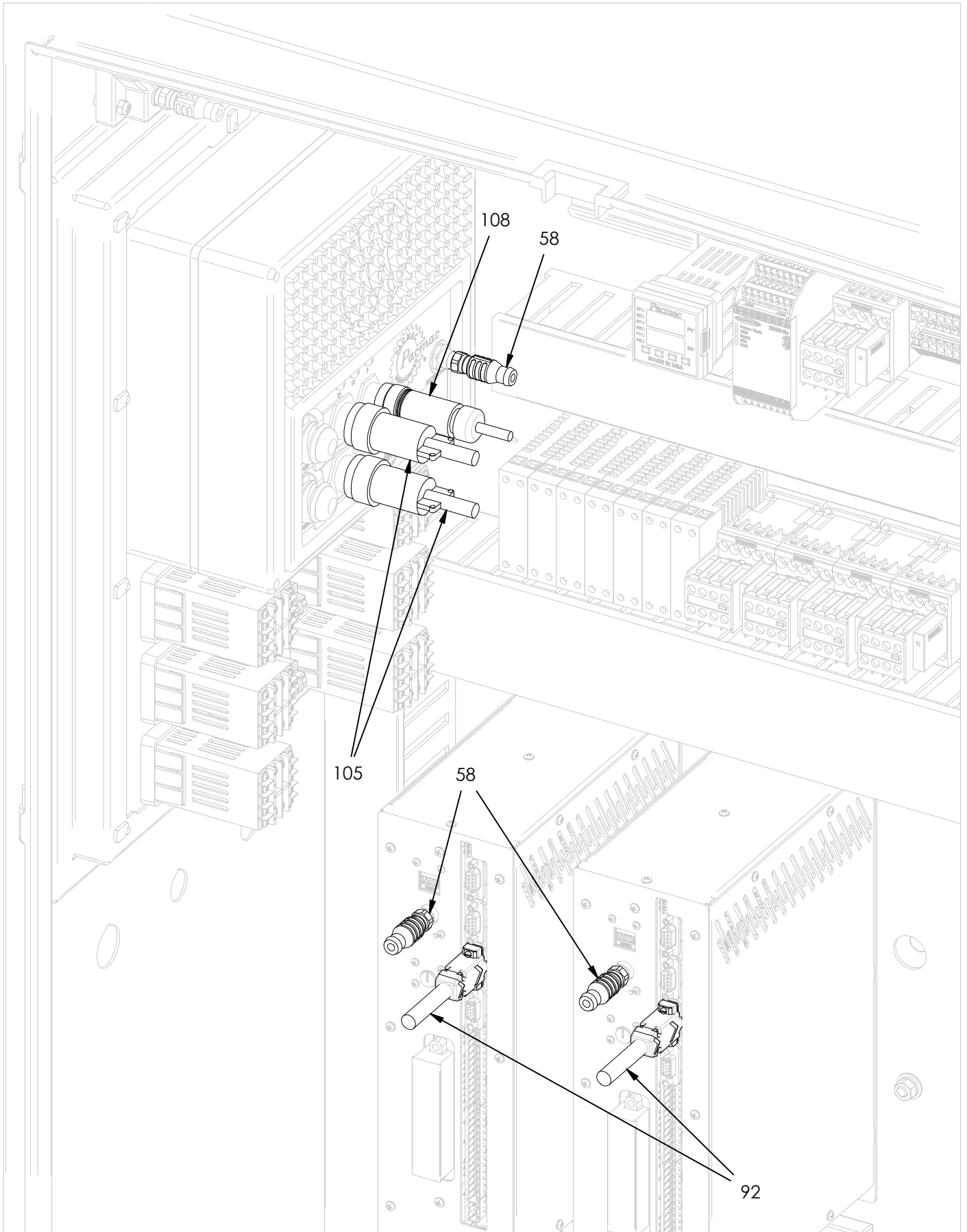
1518 Electrical Cabinet Assembly



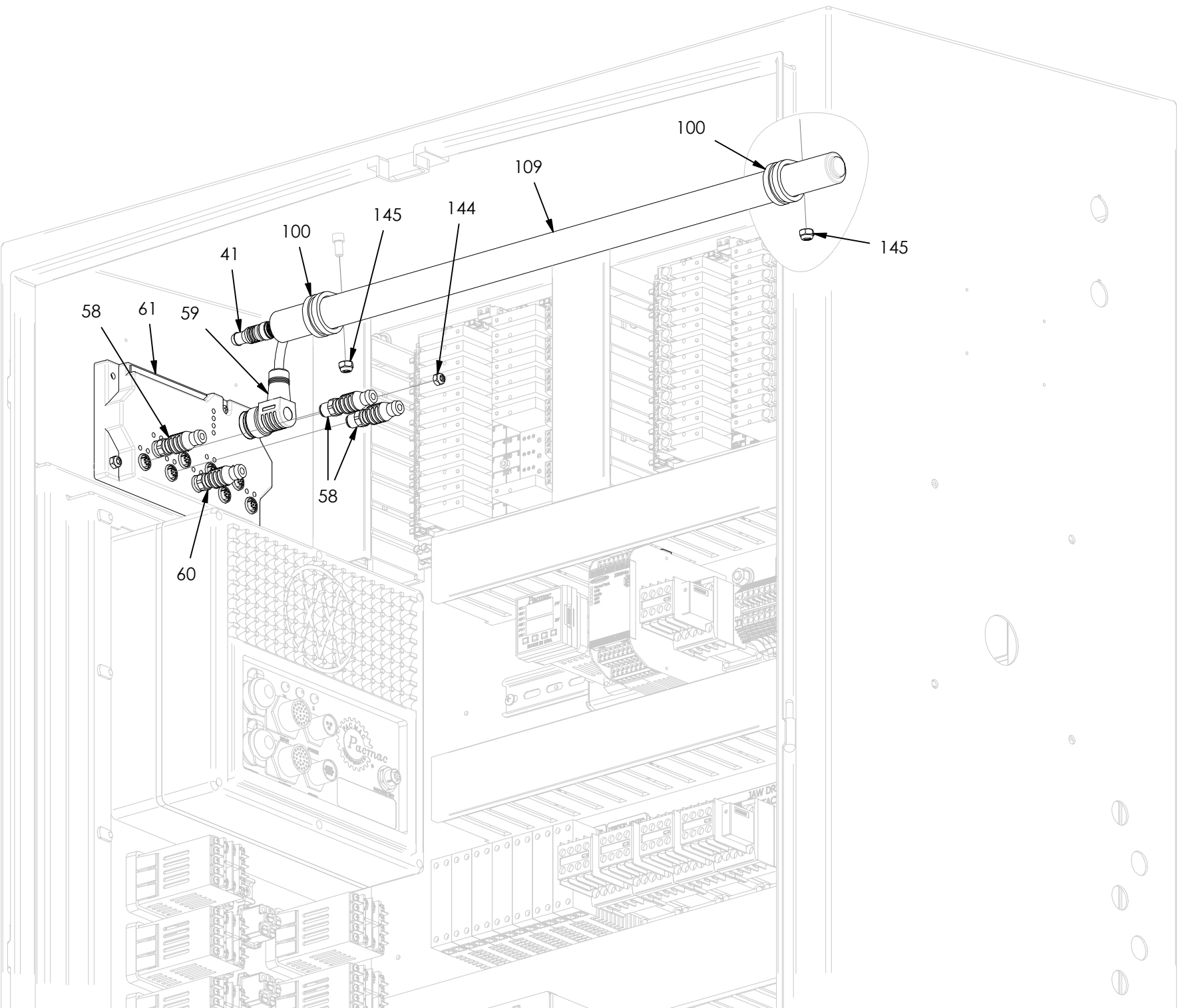
1518 Electrical Cabinet Assembly



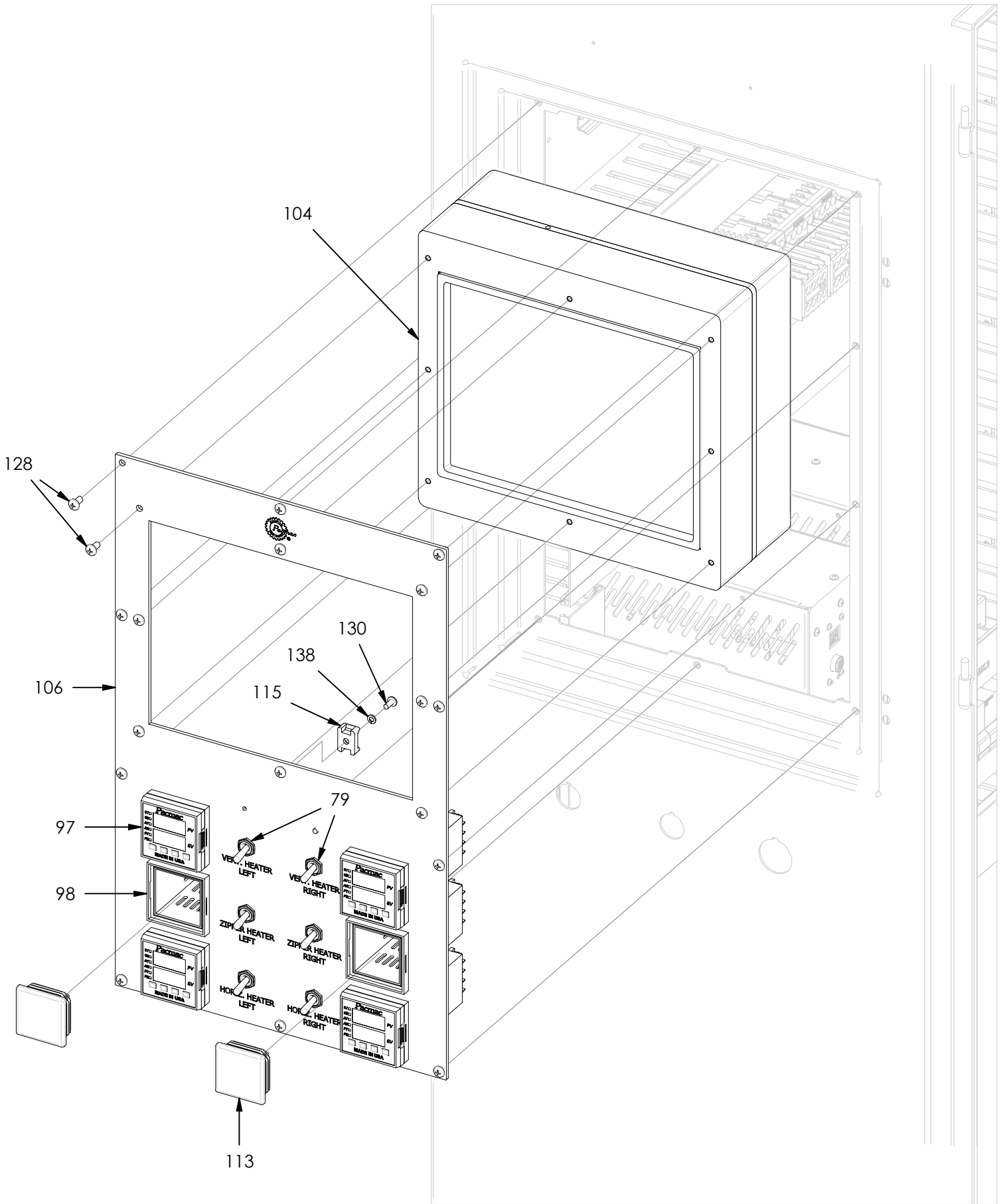
1518 Electrical Cabinet Assembly



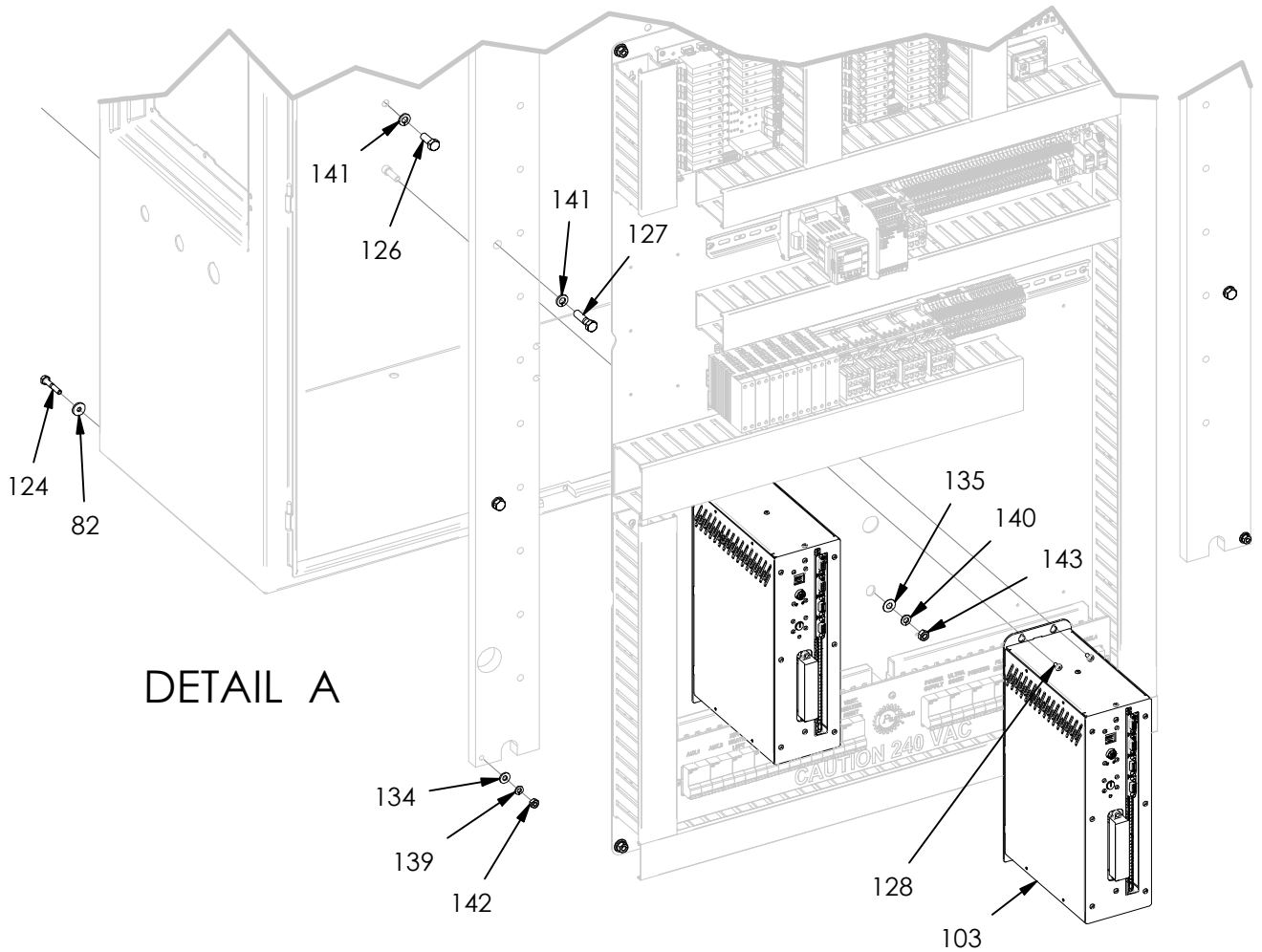
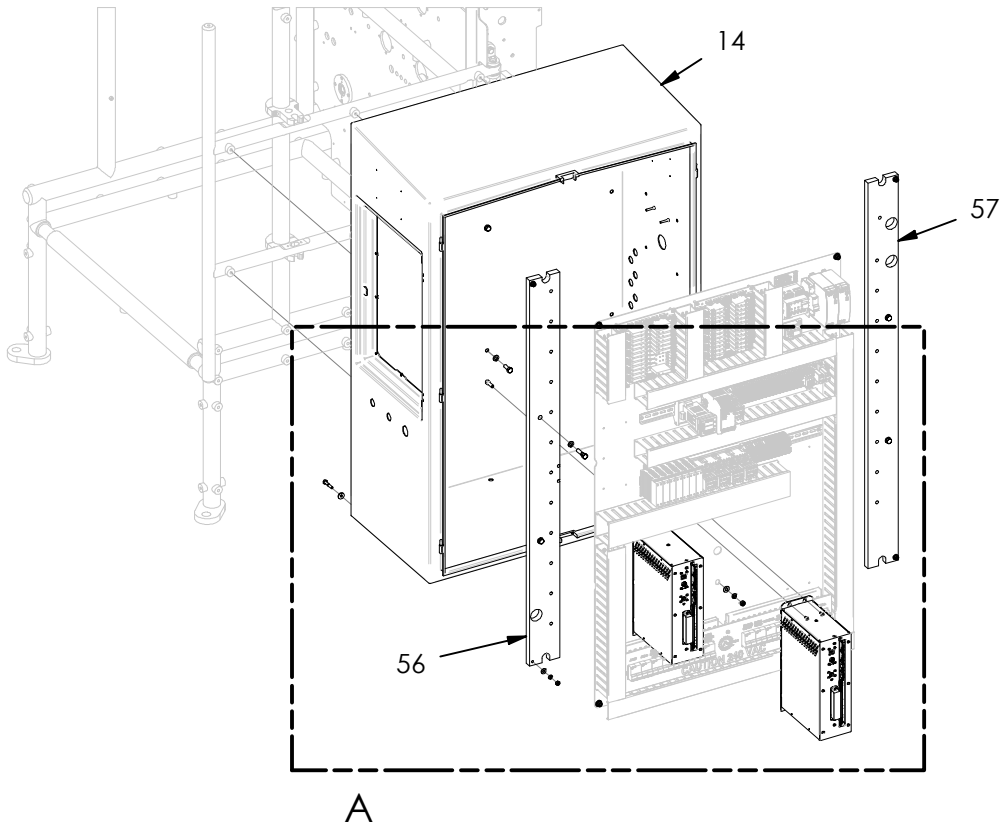
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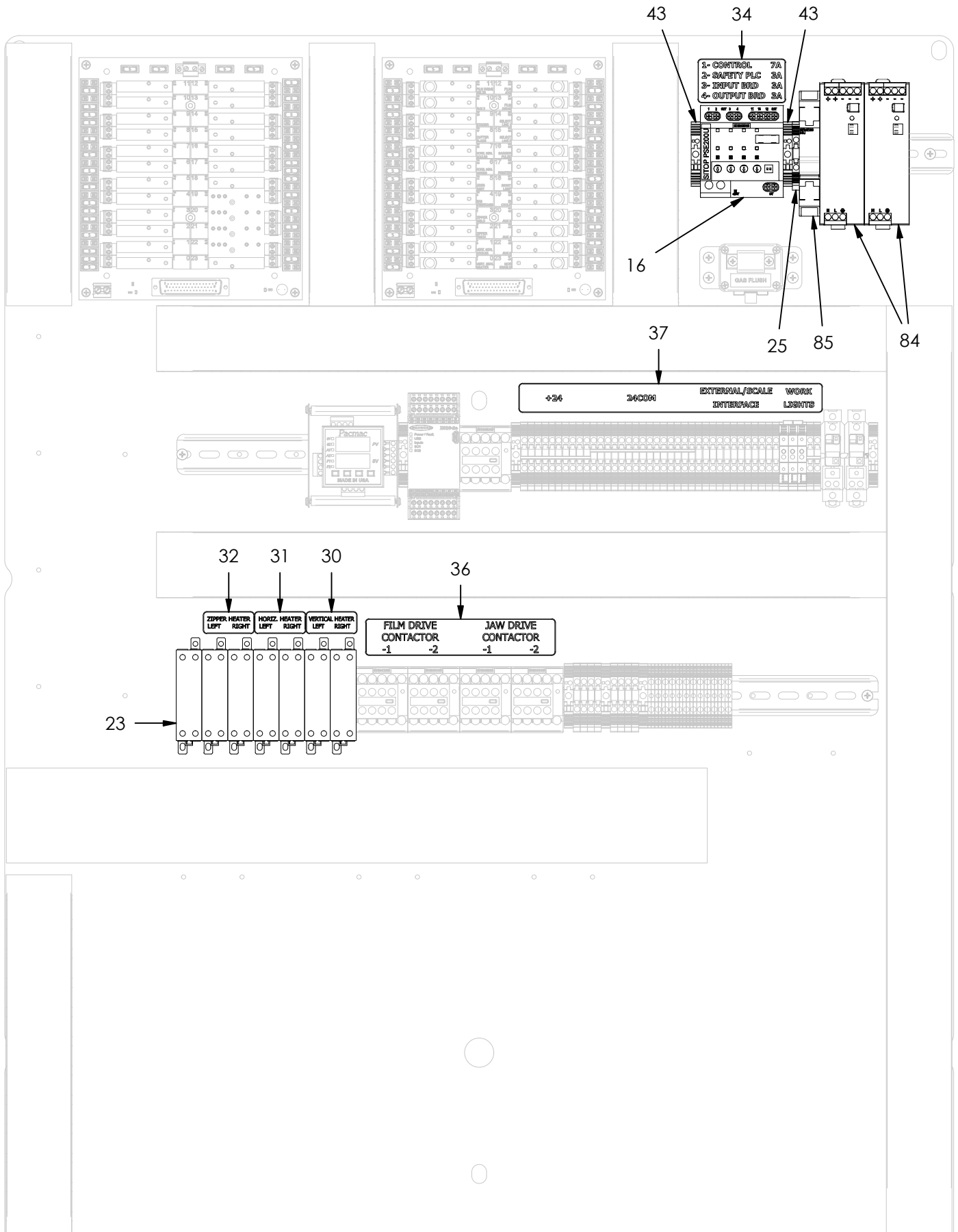
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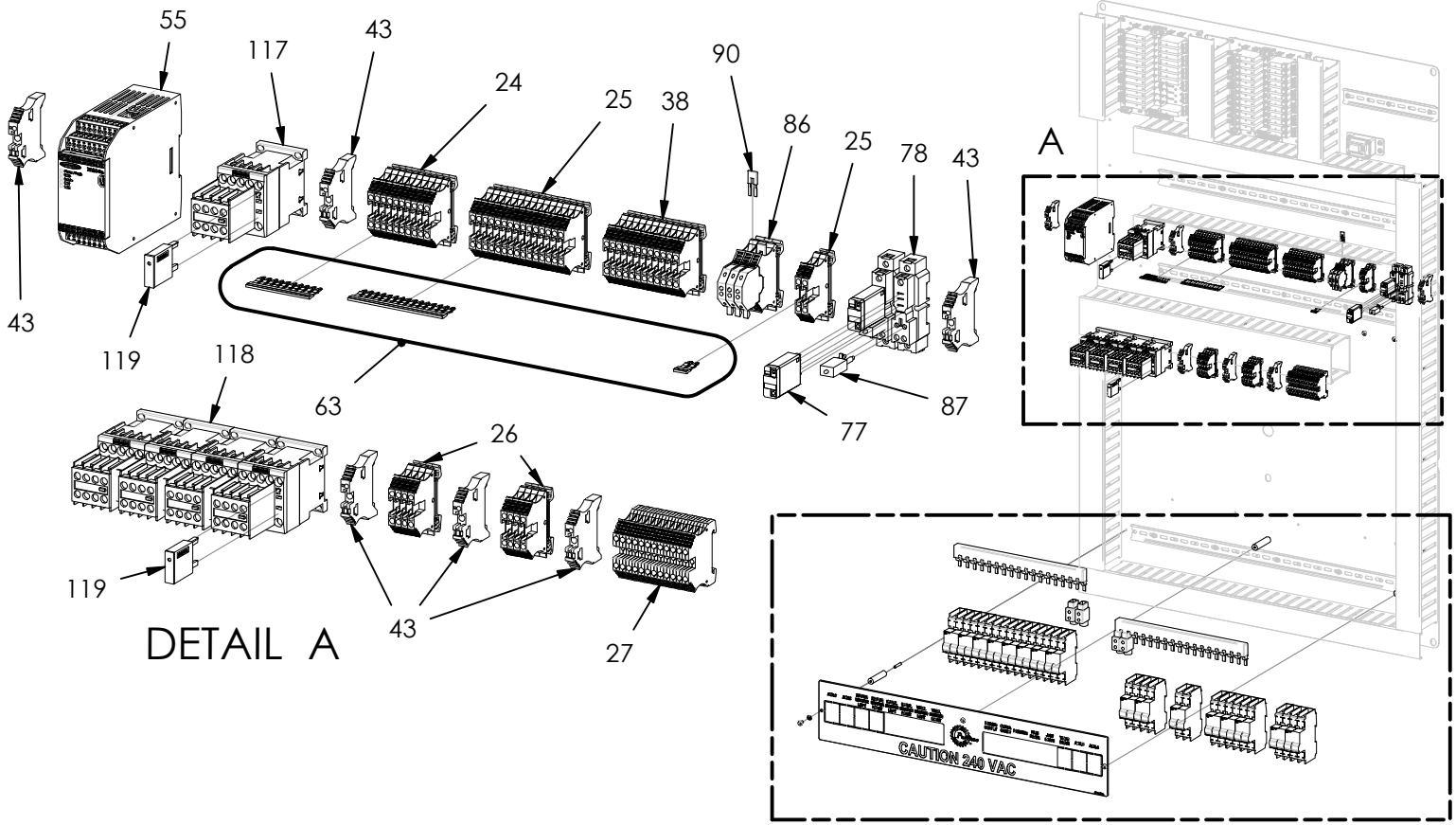
1518 Electrical Cabinet Assembly



1518 Electrical Cabinet Assembly

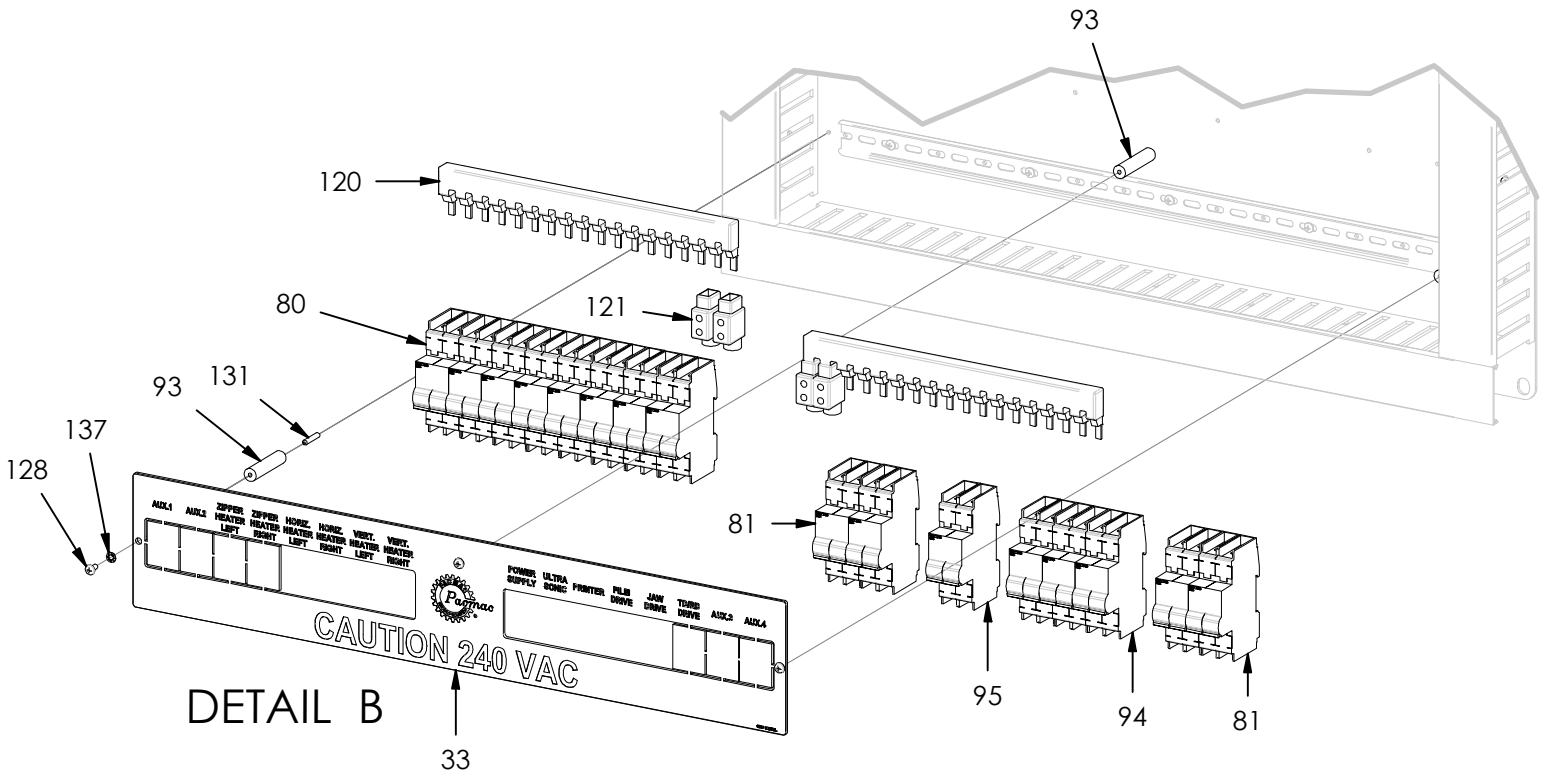


1518 Electrical Cabinet Assembly



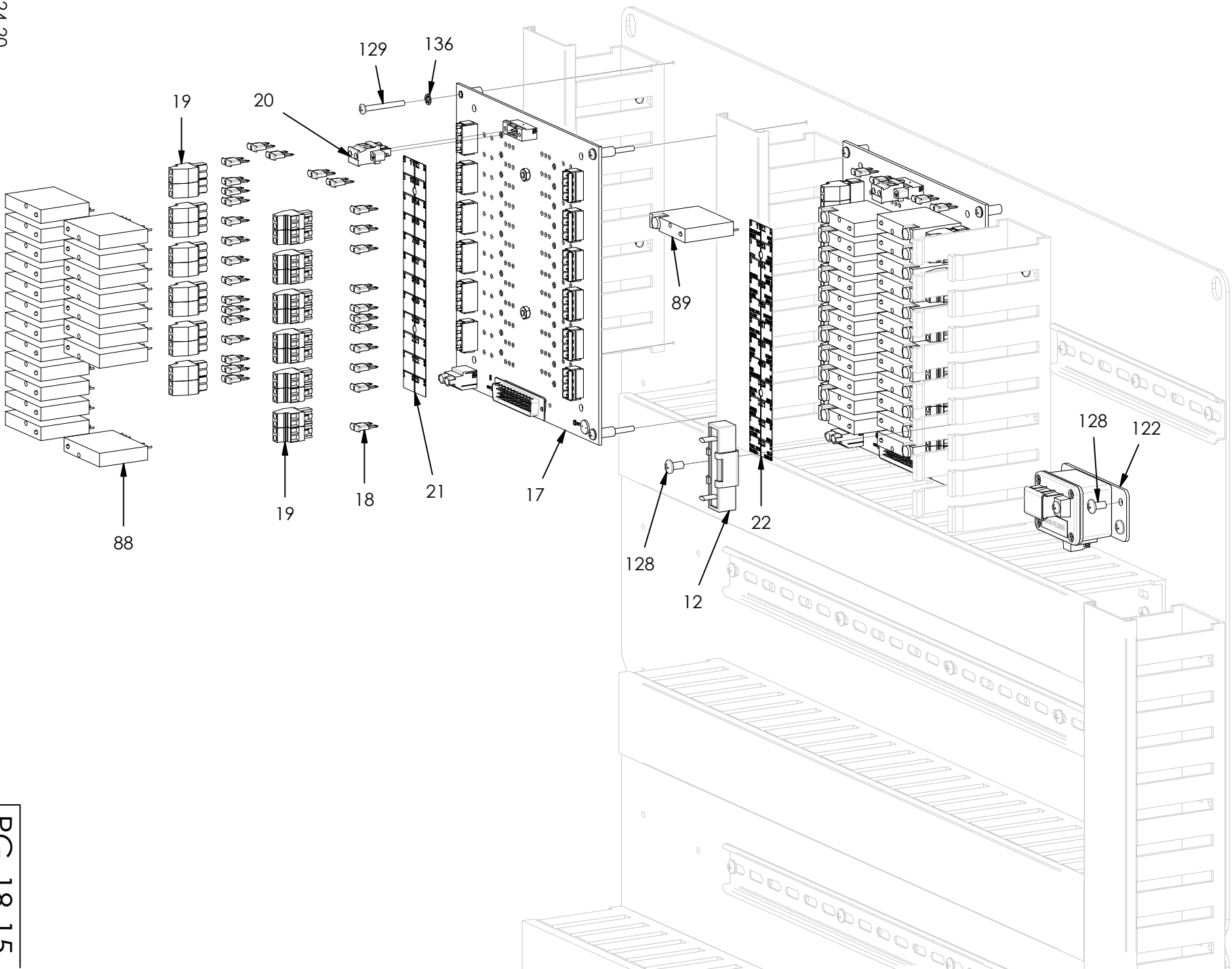
DETAIL A

B

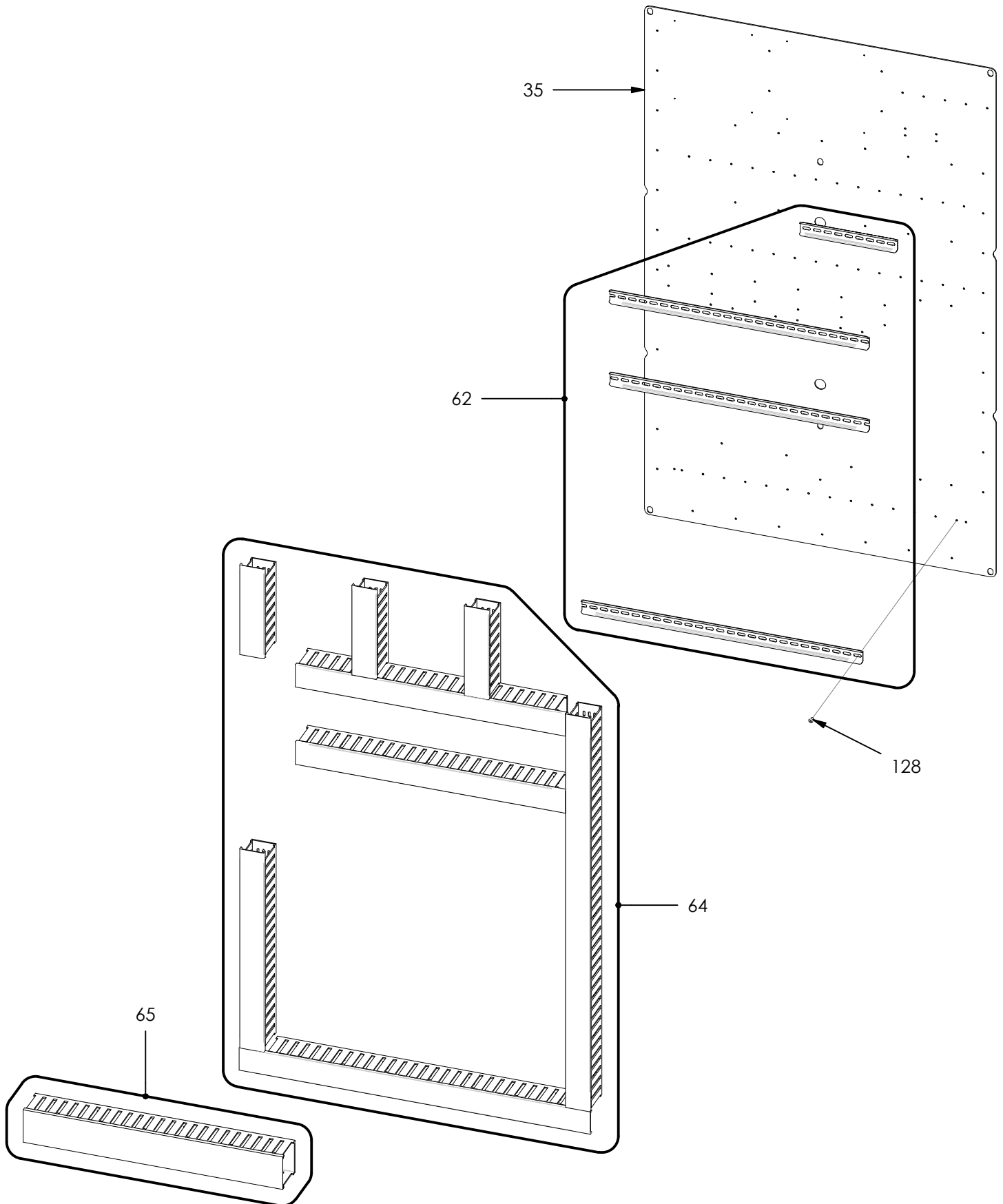


DETAIL B

1518 Electrical Cabinet Assembly



1518 Electrical Cabinet Assembly



1518 Electrical Cabinet Assembly

ITEM	PART NUMBER	DESCRIPTION	QTY
1	A1518-0019	Reset/Start Button Assembly	0
2	A1518-0105	Film Position Switch Assembly	0
3	A1518-0107	E-Stop Button Assembly	0
4	A1521-0201	Film Splice Switch Assembly	0
5		DIN Rail HD, 4.5"	1
6	1500-0202	Cord Grip	1
7	1500-0205 -9	Grommet	2
8	1500-0205X1	Cord Grip	2
9	1502-0118H -L	Horizontal Heater Cable	1
10	1502-0118H -R	Horizontal Heater Cable	1
11	1503-0077V	Vert. Heater Cable	1
12	1505-0003 -1	Linear Actuator Series Resistor	1
13	1516-0006	Air Terminal Control Cable	1
14	1518-0005MI -1	Electrical Cabinet Base	1
15	1518-0005MI -1-2	Center Post	1
16	1518-0011	Selective Power Module	1
17	1518-0012	I/O Board	2
18	1518-0012 -1	5 Amp Mini Auto Fuse	55
19	1518-0012 -2	2 Pole Connector (Black)	48
20	1518-0012 -3	2 Pole Connector (Green)	2
21	1518-0012 -I	Legend Plate, Input Board	1
22	1518-0012 -O	Legend Plate, Output Board	1
23	1518-0014	Solid State Relay	7
24	1518-0015	Terminal Block, Yellow	10
25	1518-0016	Terminal Block, Black	18
26	1518-0017	Terminal Block, Tan	8
27	1518-0018	Terminal Block, GN/Y	12
28	1518-0019	Reset Button	1
29	1518-0019 -1	LED Module	2
30	1518-0024 -1	Vertical Heater Legend Plate	1
31	1518-0024 -2	Horizontal Heater Legend Plate	1
32	1518-0024 -3	Zipper Heater Legend Plate	1
33	1518-0025	240VAC Legend Plate	1
34	1518-0026	24VDC Legend Plate	1
35	1518-0030 -1	Subpanel	1
36	1518-0049	Contactors Legend Plate	1
37	1518-0050	Terminal Block Legend Plate	1
38	1518-0063	Terminal Block, Blue	12
39	1518-0070	Emergency Stop Legend Plate	1
40	1518-0071	ResetStart Legend Plate	1

1518 Electrical Cabinet Assembly

ITEM	PART NUMBER	DESCRIPTION	QTY
41	1518-0086	Jaw/Cabinet Work Light Cable	2
42	1518-0087	Rear Work Light Cable	1
43	1518-0097	Terminal Block, End Section	8
44	1518-0100	External Disconnect Box	1
45	1518-0103	Legend Plate	1
46	1518-0105	Selector Switch	1
47	1518-0105 -1	Holder	4
48	1518-0106	N. O. Contact Block	8
49	1518-0107	22mm Push Button	1
50	1518-0108	Contact Block	1
51	1518-0109	22mm Adapter	1
52	1518-0113	Spacer	4
53	1518-0114	Plastic Fitting	1
54	1518-0115	Locknut	2
55	1518-0125	Safety PLC	1
56	1518-0154	Strongback (Front)	1
57	1518-0155	Strongback (Rear)	1
58	1518-0202	8 Pin M12 Ethernet Cable	3
59	1518-0203	Ethernet Switch Power Cable	1
60	1518-0204	1M Ethernet Cable	1
61	1518-0206	9 Port Switch	1
62	1518-A006	Din Rail Kit	1
63	1518-A007	Terminal Block Jumper Kit	1
64	1518-A008	2X3 Panduit DuctCover Kit	1
65	1518-A009	Panduit Duct/Cover Kit	1
66	1518-A209	Front Door Sensor Assy	1
67	1518-A220	Low Air Sensor Cable	1
68	1518-A221 -1	Jaw Valve Control Cable	1
69	1518-A222	Low Film Sensor Cable	1
70	1518-A223	Nip Roller Sensor Cable	1
71	1518-A224	Eye Sensor Cable	1
72	1521-0201	Switch	1
73	1521-0201 -3	LED Module	2
74	1521-100-4	Legend Plate	1
75	1521-76	Din Rail Base	1
76	1521-A003	Film Splice Heater Cable	1
77	2018-0027	Relay	2
78	2018-0028	Relay Socket	2
79	9200-0080	DPST Switch w/screw terminal	6
80	9200-0082-C	220V Breaker (10 Amp)	4

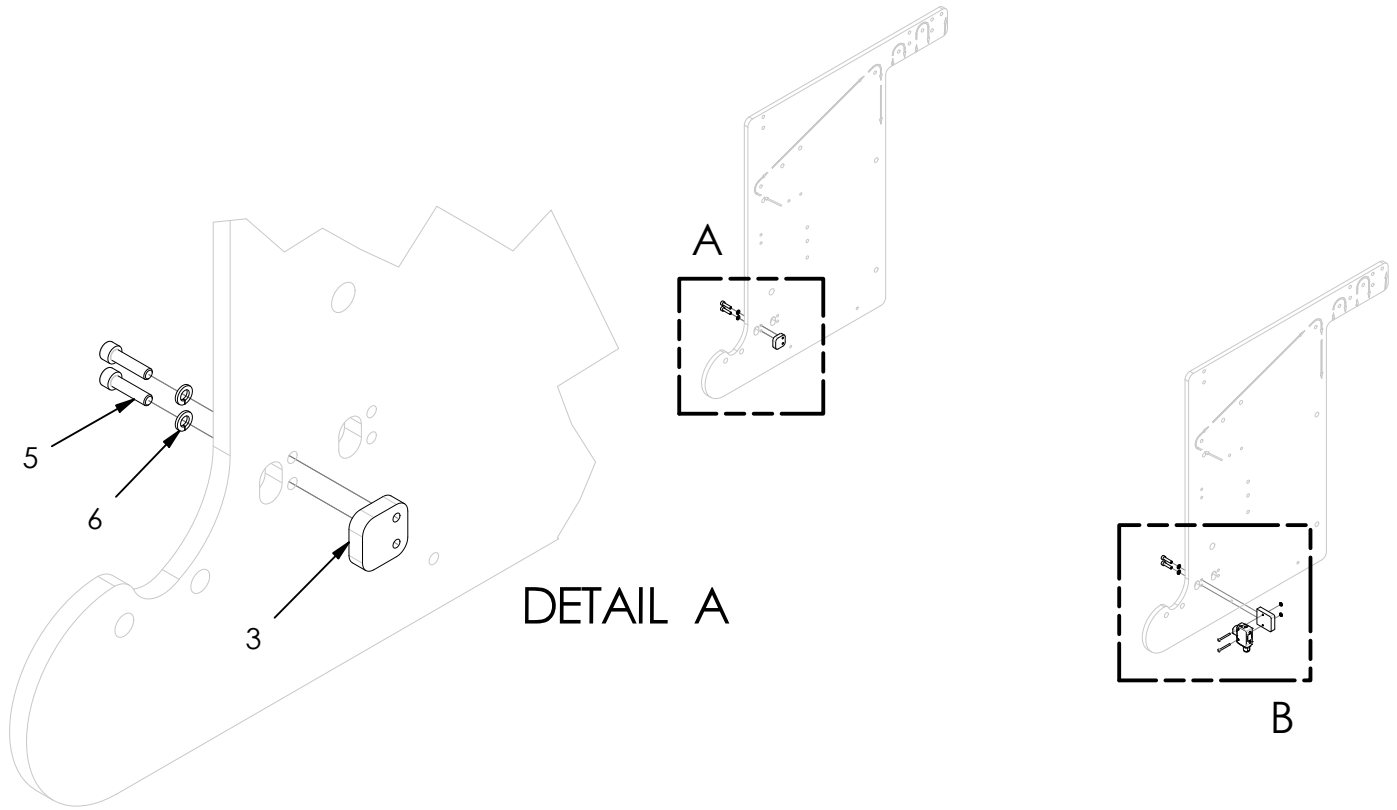
1518 Electrical Cabinet Assembly

ITEM	PART NUMBER	DESCRIPTION	QTY
81	9200-0082-D	220V Breaker (10 Amp)	4
82	9208-0016	Washer	4
83	9216-0048SS	SS Cord Grip	1
84	9218-0004P	Power Supply	2
85	9218-0011	24V Breaker (4 Amp)	1
86	9218-0015FH	Fuse Holder	3
87	9218-0017 -1	LED Module	2
88	9218-0022	Input Module	20
89	9218-0023	Output Module	24
90	9218-0028 -1	Jumper	2
91	9218-0034	Motor Cable	2
92	9218-0035 WQ	Encoder Cable	2
93	9218-0048	Stand Off	3
94	9218-0064	220V Breaker (15 Amp)	3
95	9218-0065	220V Breaker (5 Amp)	1
96	9500-111	Cord Grip	2
97	9500-76A	Temperature Controller	5
98	9500-76A -1	Housing	2
99	9516-0032	Cord Grip	13
100	9516-0090	Loom Clamp	2
101	9516-0092SS	Plug	1
102	9518-0001D -20	U.S. Power Supply	1
103	9518-0002	Servo Controller Assembly	2
104	9518-0003UL	Computer	1
105	9518-0013UL	I/O Cable Assy	2
106	9518-0033UL	Temp Control Panel	1
107	9518-0072 -2	Green Plug	0
108	9518-0079UL	Computer Power Cable	1
109	9518-0087	2' Work Light	1
110	9518-0090	Disconnect	1
111	9518-0091	Main Breaker (50 Amp)	1
112	9518-0091 -2	Breaker Spacer	2
113	9518-0109	Hole Plug	2
114	9518-0115	Grounding Lug	3
115	9518-0116	Nylon Tie Mount	2
116	9518-0117	Label, Ground Symbol	1
117	9518-0126	MCR Safety Relay	1
118	9518-0127	Motor Contactor	4
119	9518-0128	Surge Suppressor	5
120	9518-A206 -18	220 VAC Jumper Bar	2

1518 Electrical Cabinet Assembly

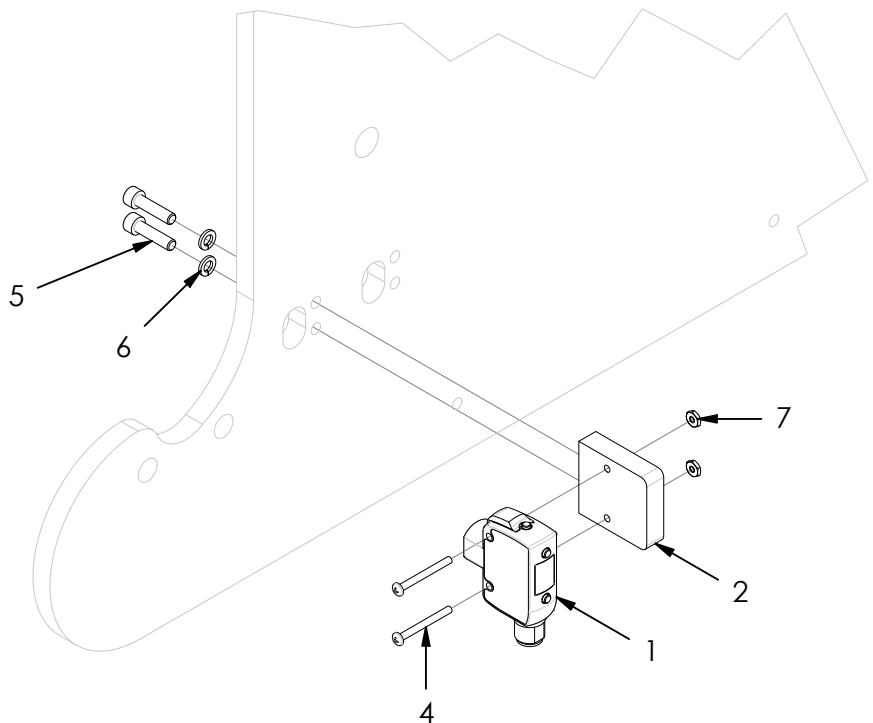
ITEM	PART NUMBER	DESCRIPTION	QTY
121	9518-A206 -3	Busbar Infeed	4
122	9541-0100	Gas Flush Filter Assy	0
123	RSSS-311-LR	Cord Grip, SS	1
124	1/4-20X1 1/2HH	Hex Head Bolt	4
125	5/16-18X1 1/4HH	Hex Head Bolt	4
126	3/8-16X1HH	Hex Head Bolt	2
127	3/8-16X1 1/2HH	Hex Head Bolt	4
128	10-32X3/8PPH	Phillips Pan Head Screw	83
129	6-32X1 1/4PPH	Phillips Pan Head Screw	8
130	8-32X3/8PPH	Phillips Pan Head Screw	2
131	10-32SS	Set Screw	3
132	10-32X3/8SH	Socket Head Bolt	2
133	10-32X1SH	Socket Head Bolt	2
134	1/4FW	Flat Washer	4
135	5/16FW	Flat Washer	8
136	#6LWIT	Internal Tooth Lock Washer	8
137	#10LWIT	Internal Tooth Lock Washer	3
138	#8LW	Lock Washer	2
139	1/4LW	Lock Washer	8
140	5/16LW	Lock Washer	10
141	3/8LW	Lock Washer	6
142	1/4-20HN	Hex Nut	4
143	5/16-18HN	Hex Nut	6
144	10-32LN	Lock Nut	4
145	1/4-20LN	Lock Nut	16
146	5/16-18LN	Lock Nut	4
147	M6HN	Hex Nut	3

1519L Low Film Assembly



DETAIL A

DETAIL B



1519L Low Film Assembly

ITEM	PART NUMBER	DESCRIPTION	QTY
1	1505-0100	Low Film Sensor	1
2	1505-0103 -2	Sensor Mount	1
3	1505-0106	Backup Plate	1
4	4-40X1 1/8PPH	Phillips Pan Head Screw	2
5	10-32X3/4SH	Socket Head Bolt	4
6	#10LW	Lock Washer	4
7	4-40HN	Hex Nut	2



Low Film Sensor Programming Procedure

1505-0100 Low Film Sensor [Keyence LR-ZH490CB Laser Sensor]

- 1) Initial Setting (Set to NPN):
 - a) When powered up, PnP will be flashing on the display.
 - b) Press "**UP**" for < 1 second. Display will flash nPn.
 - c) Press and hold "**SET**" for > 3s. 000

- 2) Change Output to Dark On:
 - a) Press and hold "**UP**" for > 3s. Release. Lon
 - b) Press "**DOWN**" for < 1s. Release. Display will flash Don then 000.

- 3) Set Sensitivity (to detect when film is not present):
 - a) Confirm sensor is mounted properly and that the laser is looking across the machine at the brake hub or backup plate with *nothing* in its path.
 - b) Press and hold "**SET**" for > 3s. Release. Display will flash set then 000.

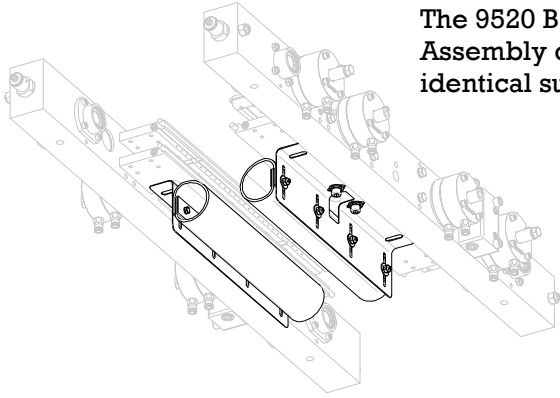
Wiring Guide:

- 1) Brown = +24 (Yellow Terminal Block)
- 2) Blue = 24COM (Black Terminal Block)
- 3) White = I-18 (Input Board)
- 4) Black = Not Used
- 5) Jump +24VDC to I-17 on Input Board

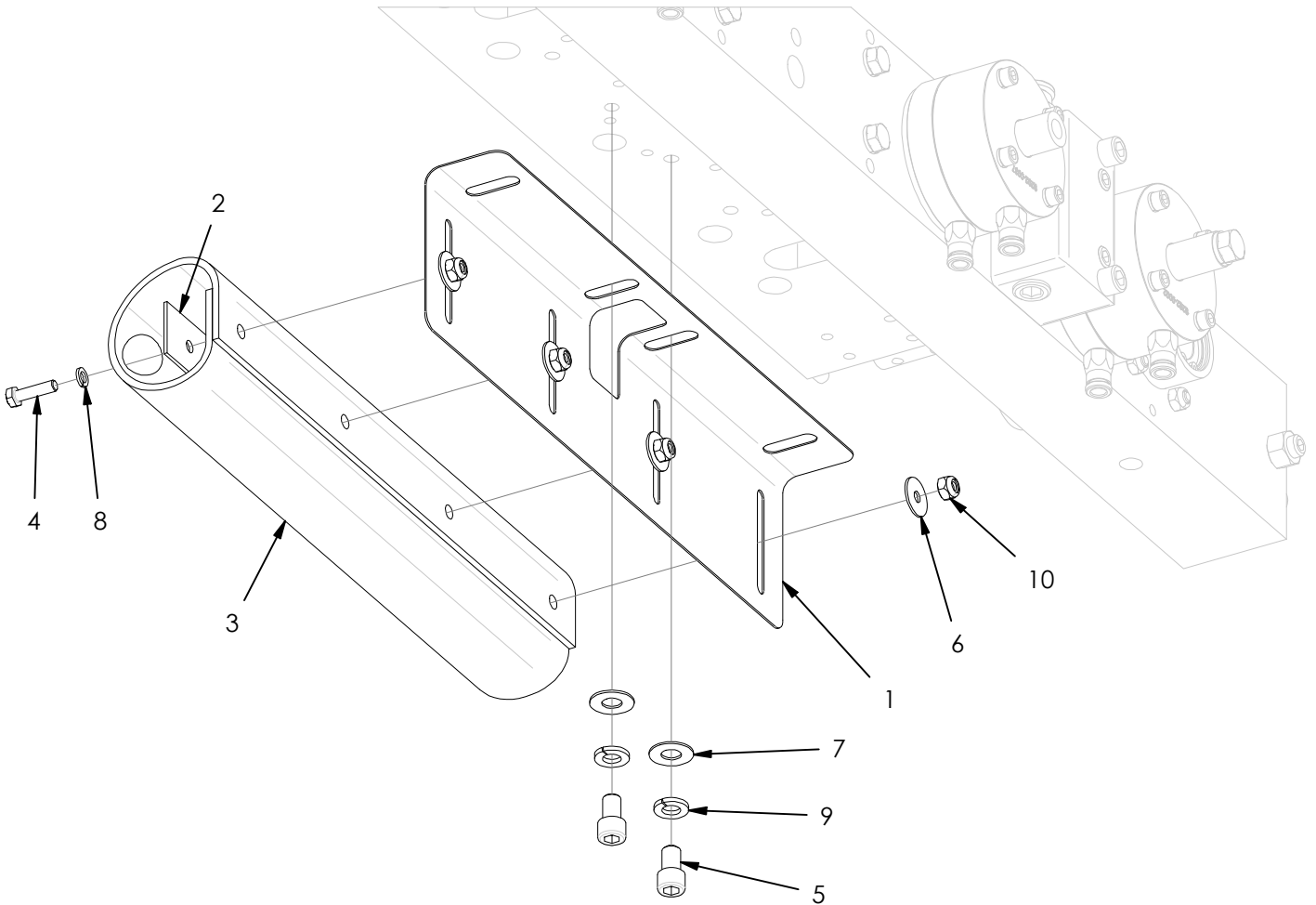
To Reset Sensor to Factory Defaults (Initialization):

- 1) Press and hold "**DOWN**", then press "**UP**" 5 times. Release both. rSt
- 2) Press "**UP**" for < 1s. Release. No
- 3) Press "**UP**" for < 1s again. Release. YES
- 4) Press "**DOWN**" for < 1s. Release. Display will flash --- then pnp.

9520 Bag Deflator Assembly



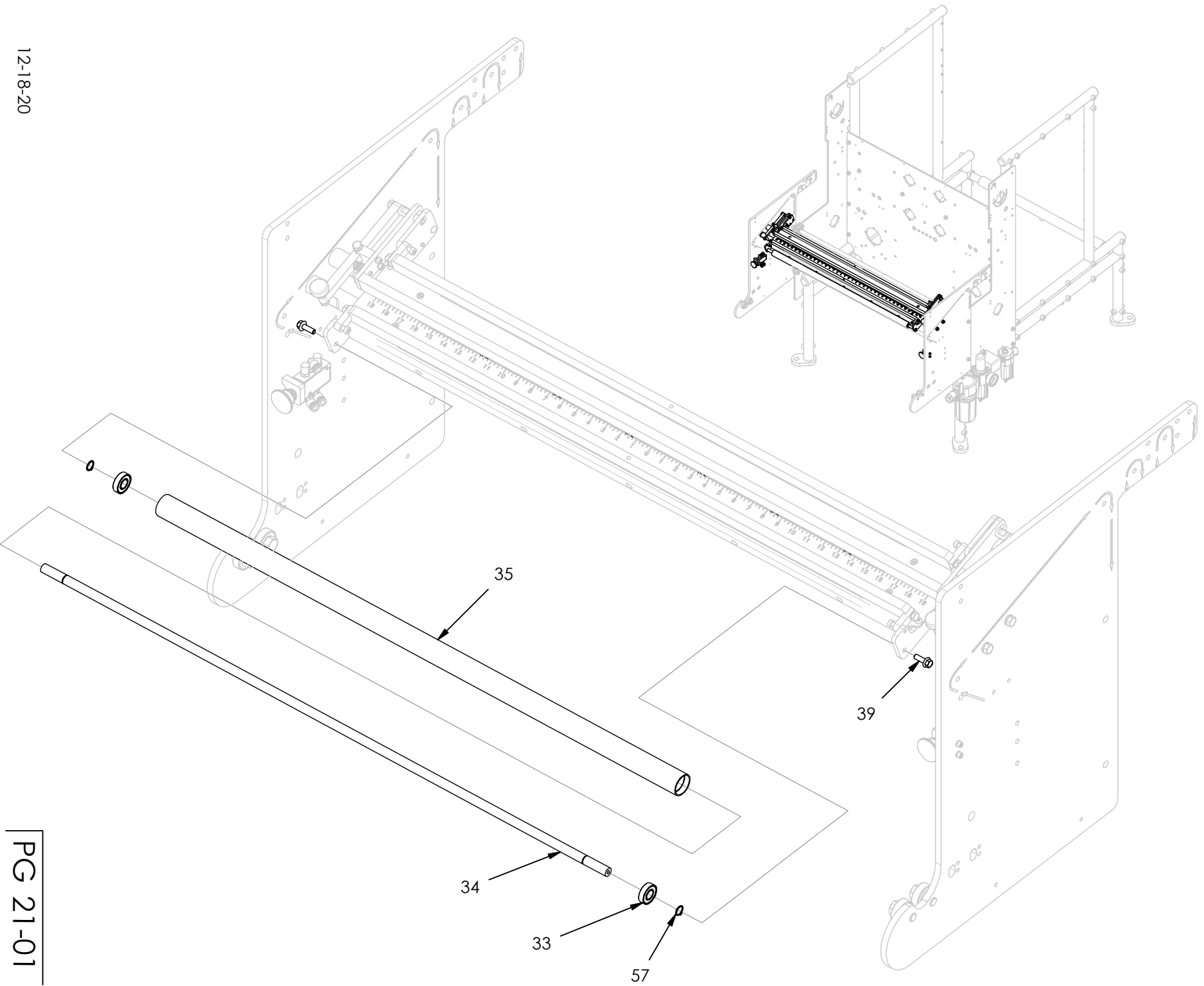
The 9520 Bag Deflator Assembly consists of two identical sub-assemblies.



9520 Bag Deflator Assembly

ITEM	PART NUMBER	DESCRIPTION	QTY
1	9220-0001	Angle	2
2	9220-0002	Clamp	2
3	9220-0003	Belt	2
4	10-32X3/4HH	Hex Head Bolt	8
5	5/16-18X1/2SH	Socket Head Bolt	4
6	#10FENDER WASHER	Fender Washer	8
7	5/16FW	Flat Washer	4
8	#10LW	Lock Washer	8
9	5/16LW	Lock Washer	4
10	10-32LN	Lock Nut	8

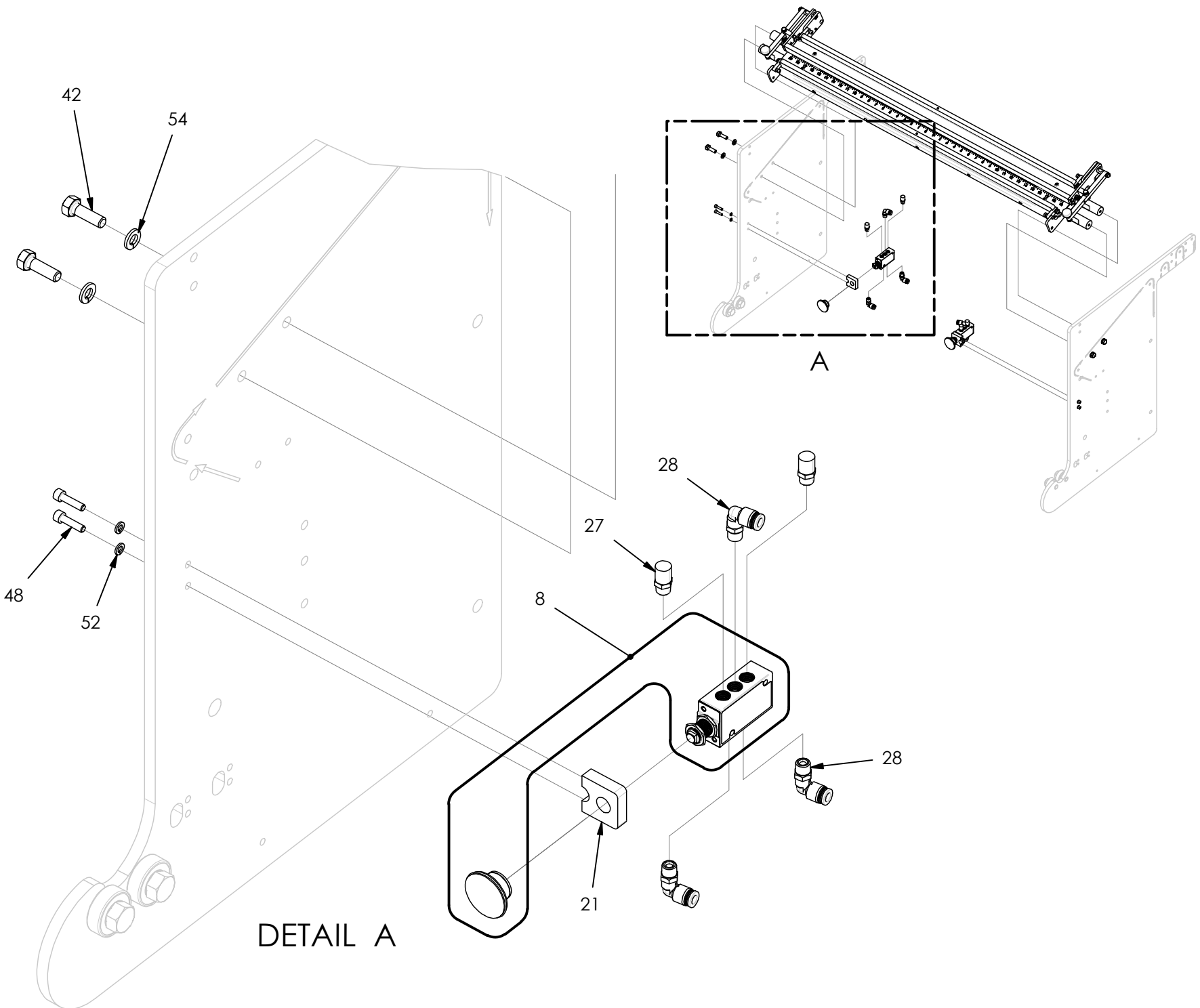
1521V2 Film Splice Assembly



12-18-20

PG 21-01

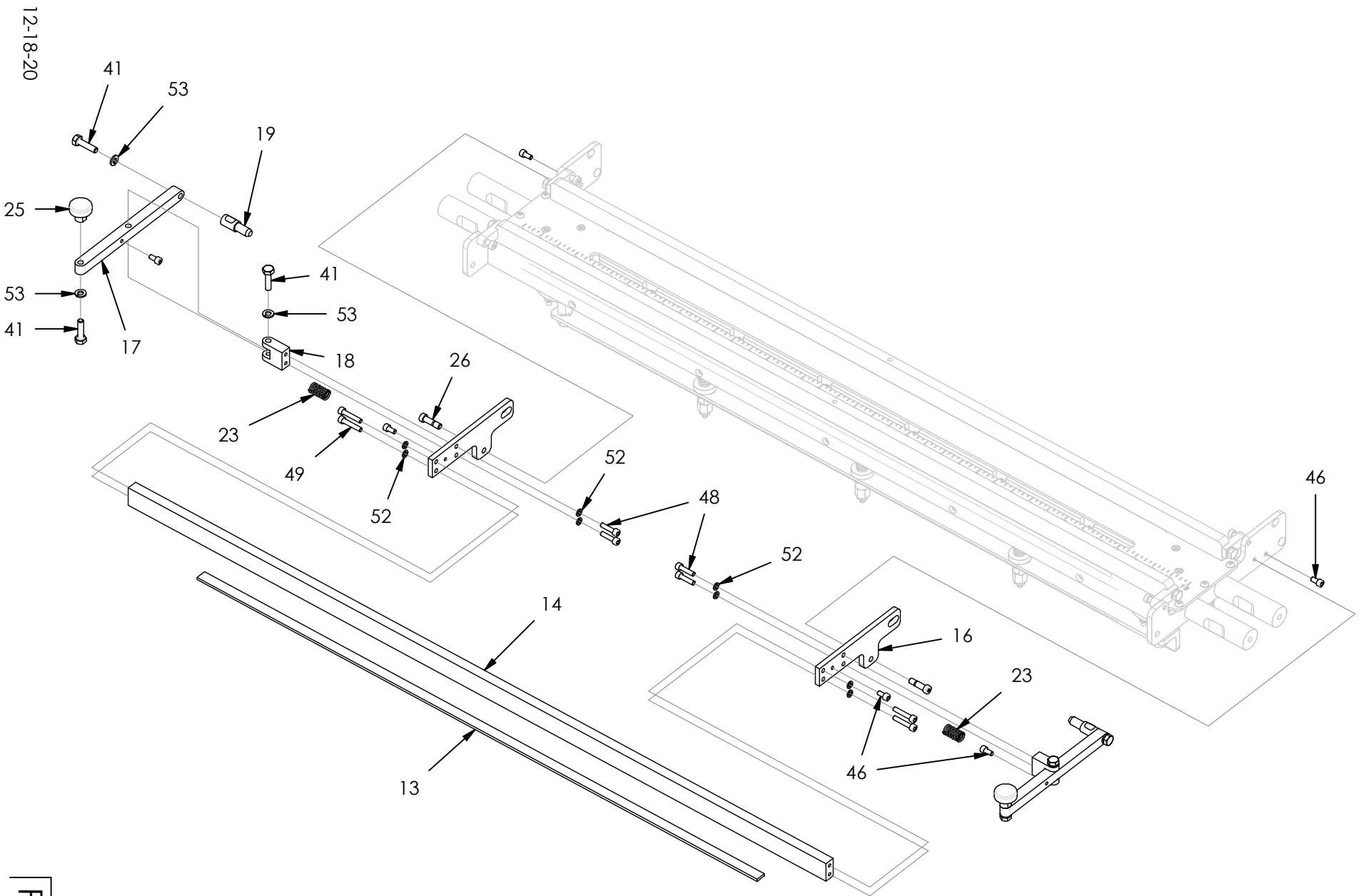
1521V2 Film Splice Assembly



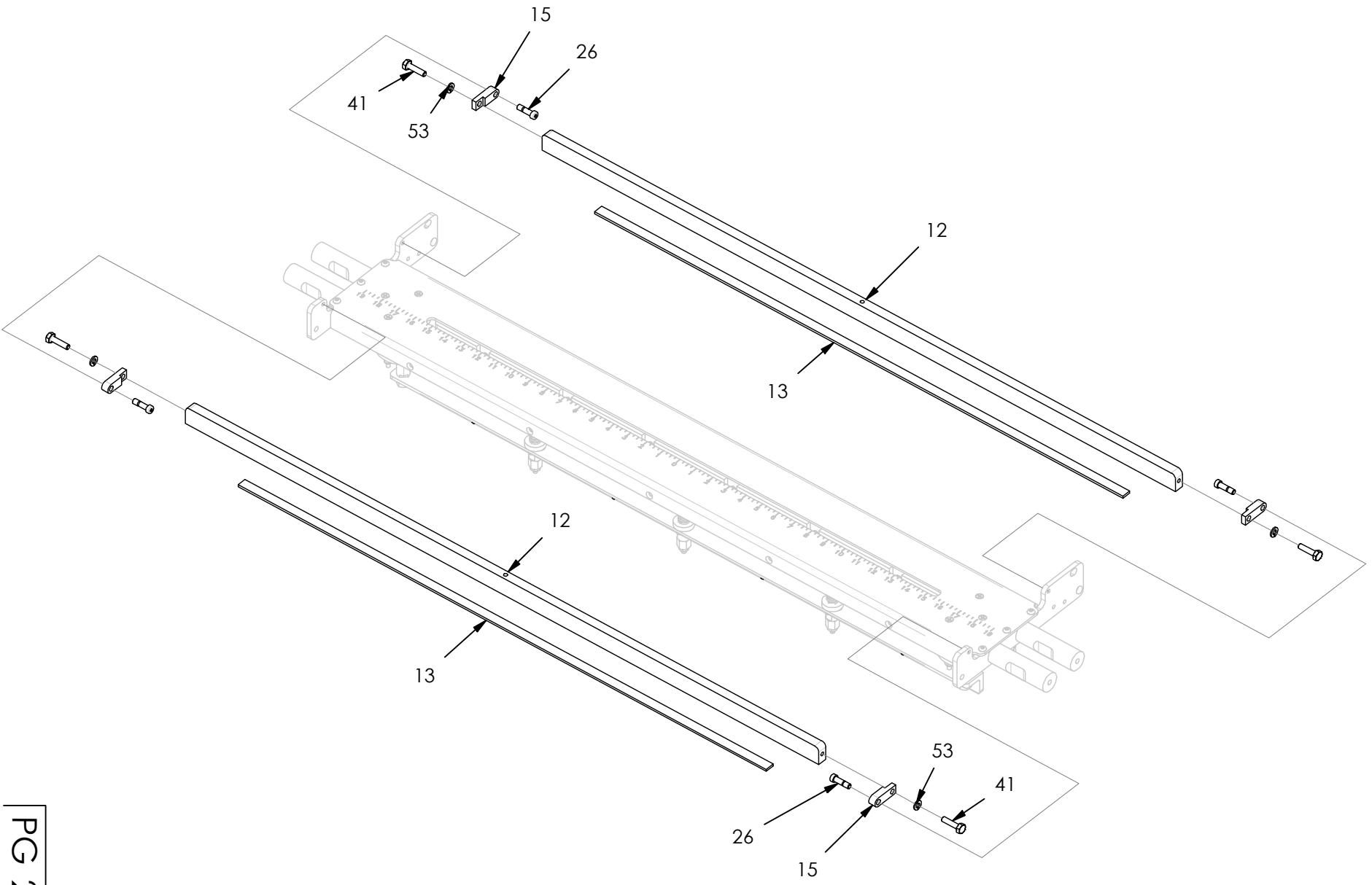
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PG 21-02

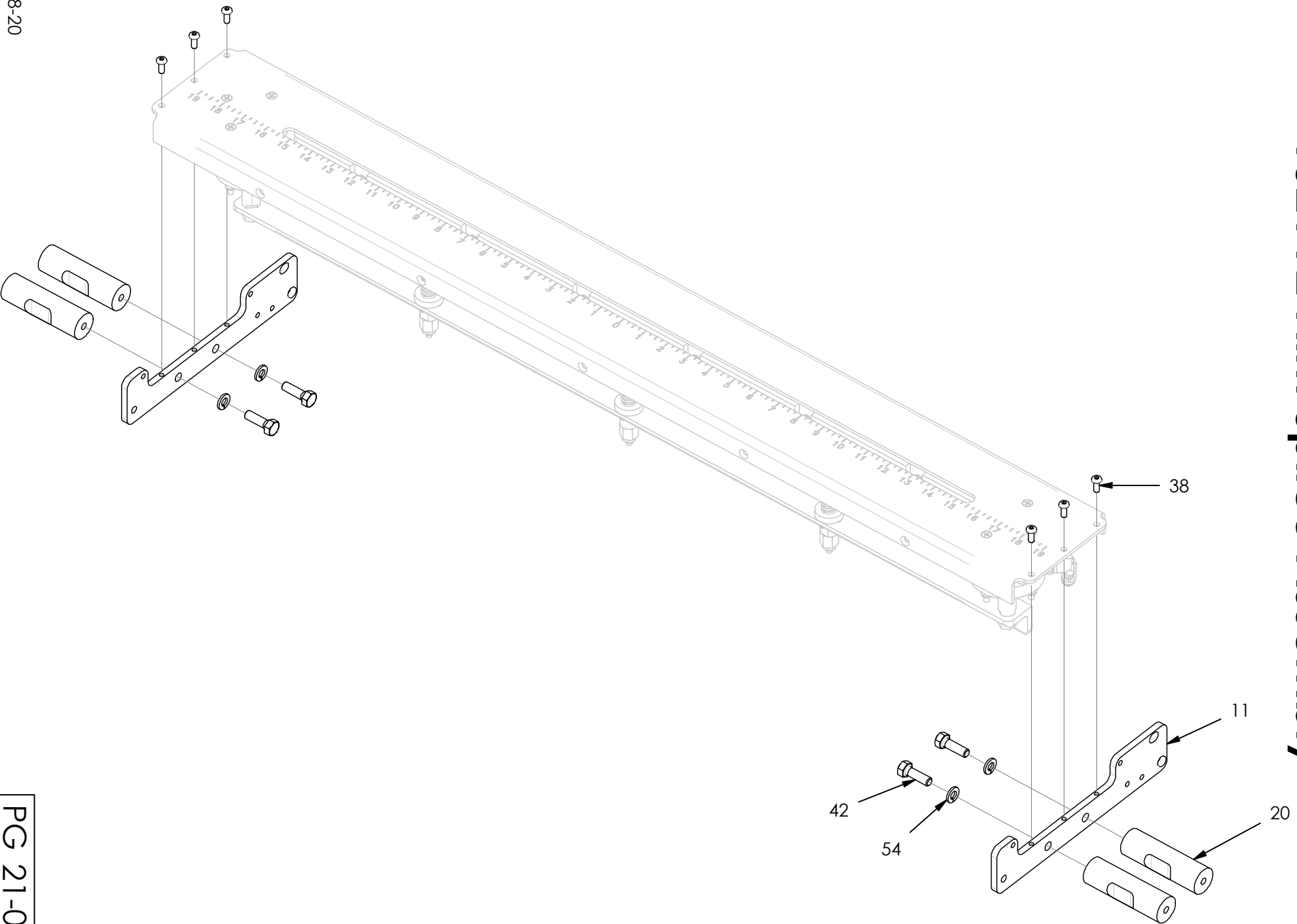
1521V2 Film Splice Assembly



1521V2 Film Splice Assembly

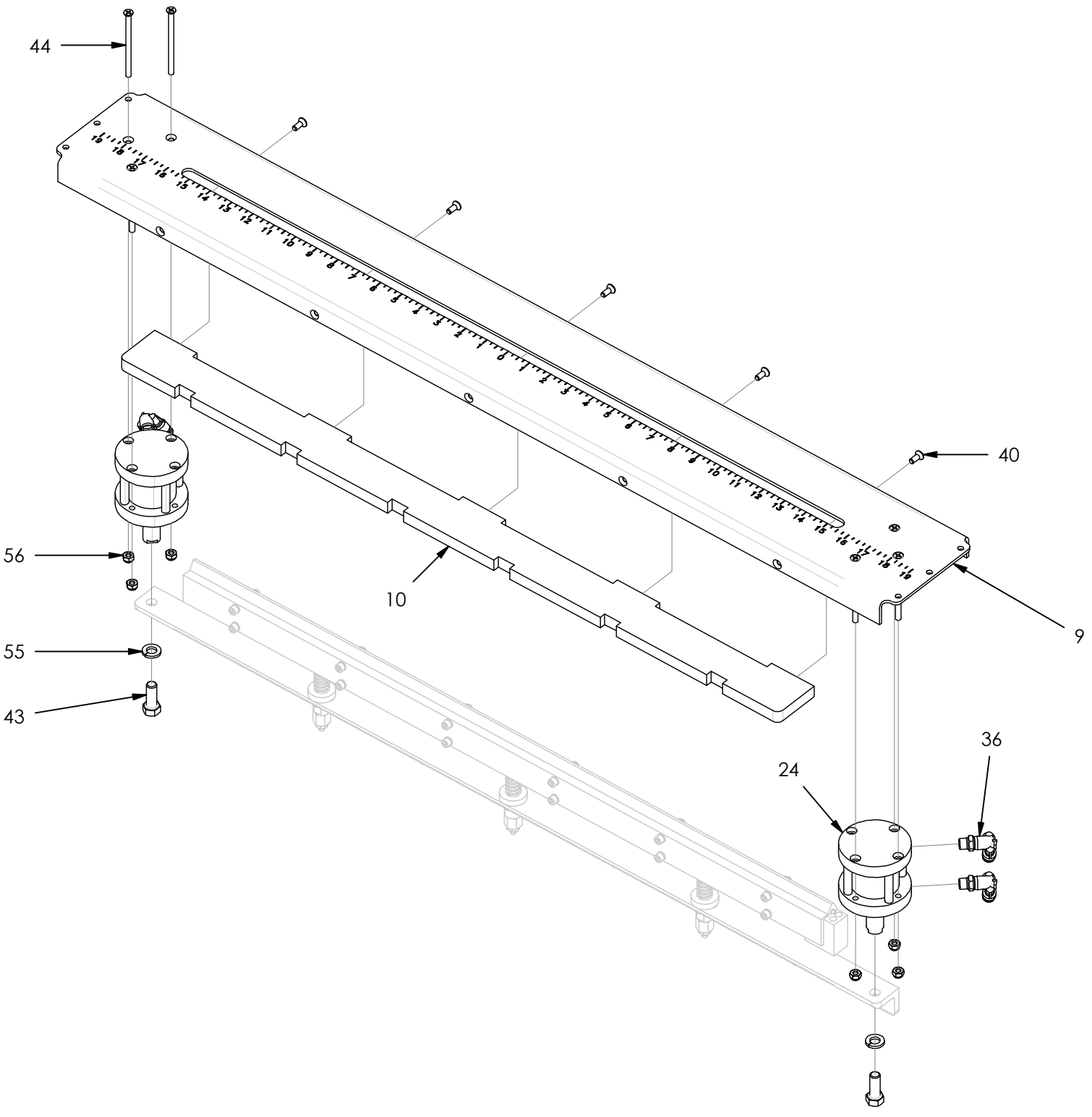


1521V2 Film Splice Assembly

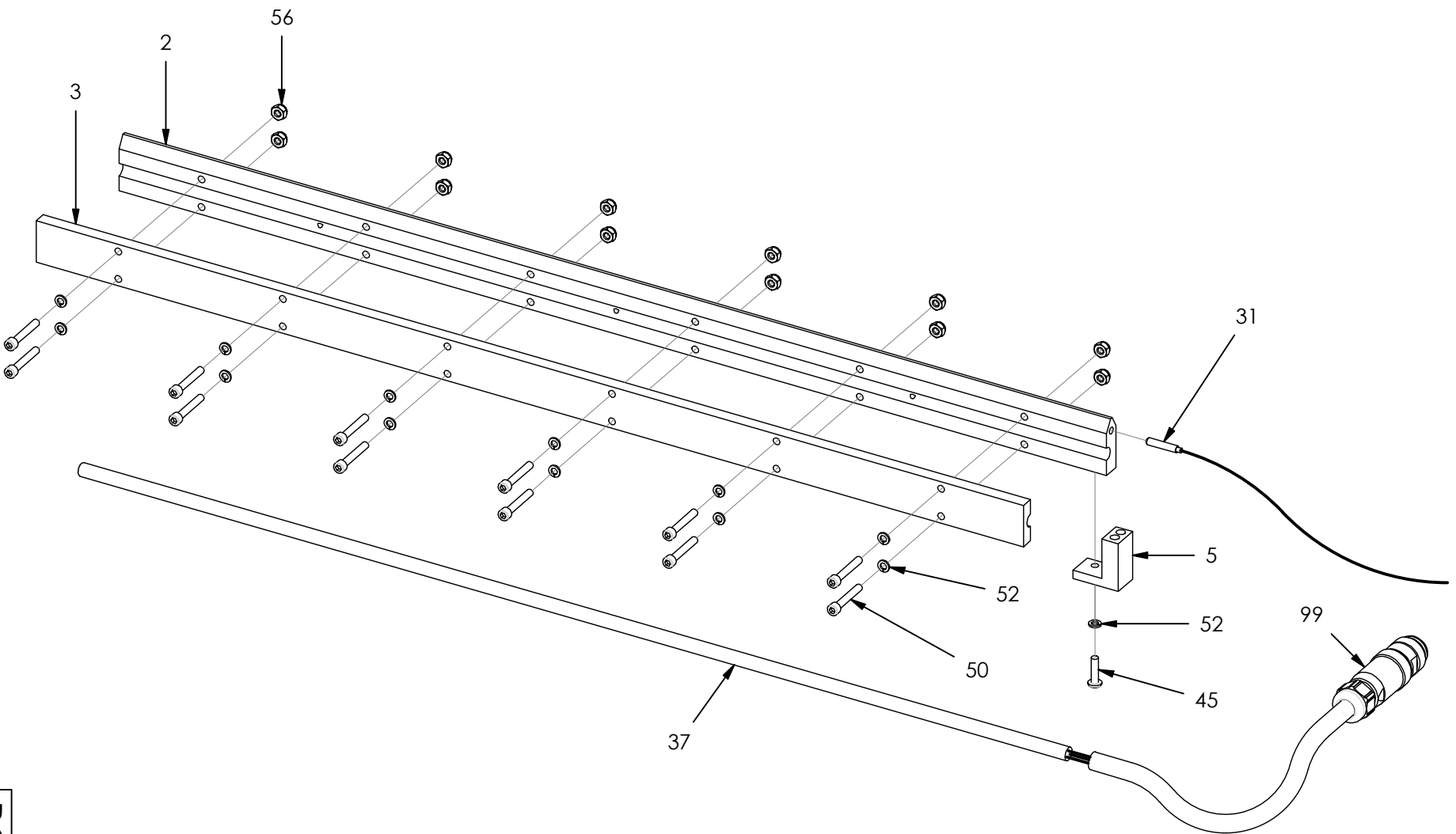


12-18-20

1521V2 Film Splice Assembly



1521V2 Film Splice Assembly



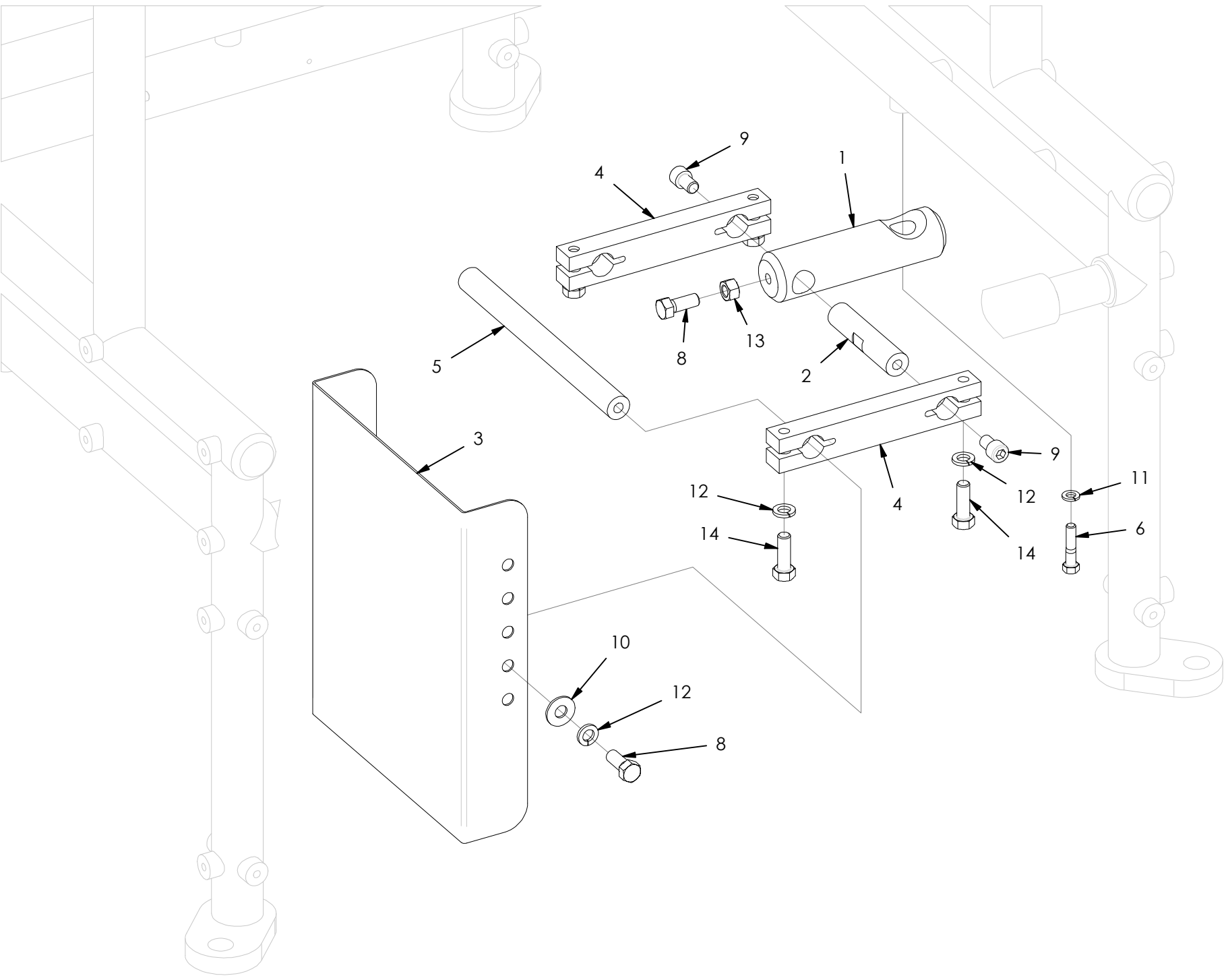
1521V2 Film Splice Assembly

ITEM	PART NUMBER	DESCRIPTION	QTY
1	A1521-0001EC	Heater Bar Assembly	0
2	1521-0001	Heater Bar	1
3	1521-0001-1	Heater Bar Cap	1
4	1521-0003	Mounting Bar	1
5	1521-0004	Wire Channel	1
6	1521-0006	Bushing	2
7	1521-0007	Bushing	1
8	1521-0038	Sealing Air Valve	2
9	1521-0102	Splice Table	1
10	1521-0103	Insulating Plate	1
11	1521-0104	Splicer Side Frame	2
12	1521-0105	Film Holding Bar	2
13	1521-0105 -1	Silicone Strip	96"
14	1521-0106	Backup Bar	1
15	1521-0107	Hinge	4
16	1521-0108	Pivot Arm	2
17	1521-0109	Locking Lever	2
18	1521-0110	Clevis	2
19	1521-0111	Locking Pin	2
20	1521-0112	Spacer	4
21	1521-0115	Valve Mount	2
22	1521-0121	Spring	3
23	1521-0122	Spring	2
24	1521-0123	Air Cylinder	2
25	1521-0124	Knob	2
26	1521-0125	Shoulder Bolt	6
27	1521-0126	Muffler	4
28	9200-0046	Tubing Connector	6
29	9200-0069	Grease Zerk	3
30	9212-0048	Cushion Clamp	4
31	9221-0011	Probe	1
32	9221-0027	Shoulder Bolt	3
33	9500-25	Bearing	2
34	9500-57	Shaft	1
35	9500-65	Roller	1
36	9500-93	Tubing Connector	4
37	9503-0014X30	Heat Rod	1
38	10-32X1/2BH	Button Head Screw	6
39	1/4-20X3/4FB	Flange Bolt	2
40	10-32X1/2FH	Flat Head Bolt	5

1521V2 Film Splice Assembly

ITEM	PART NUMBER	DESCRIPTION	QTY
41	1/4-20X1HH	Hex Head Bolt	10
42	5/16-18X1HH	Hex Head Bolt	8
43	3/8-24X1HH	Hex Head Bolt	2
44	10-32X3PFH	Phillips Flat Head Screw	6
45	10-32X3/4PPH	Phillips Pan Head Screw	1
46	10-32X3/8SH	Socket Head Bolt	6
47	10-32X1/2SH	Socket Head Bolt	4
48	10-32X3/4SH	Socket Head Bolt	8
49	10-32X1SH	Socket Head Bolt	4
50	10-32X1 1/4SH	Socket Head Bolt	12
51	#10FW	Flat Washer	4
52	#10LW	Lock Washer	29
53	1/4LW	Lock Washer	10
54	5/16LW	Lock Washer	8
55	3/8LW	Lock Washer	2
56	10-32LN	Lock Nut	22
57	1/2EXT	Snap Ring	2
58	5/8 EXT	Snap Ring	3
99	9202-0074 -4	Male Receptacle	0

1589SS Bag Slide Assembly



1589SS Bag Slide Assembly

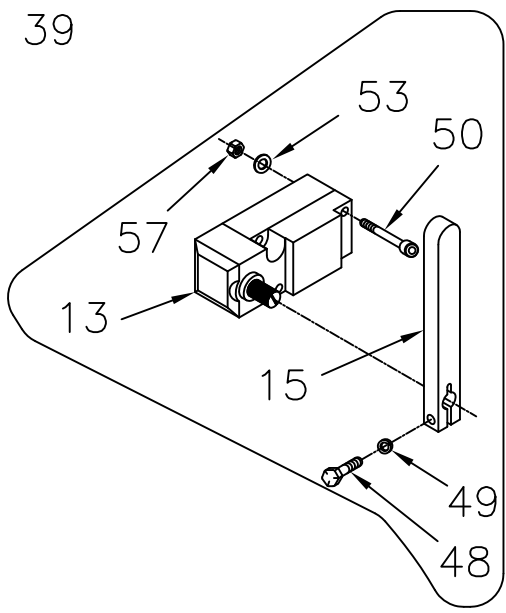
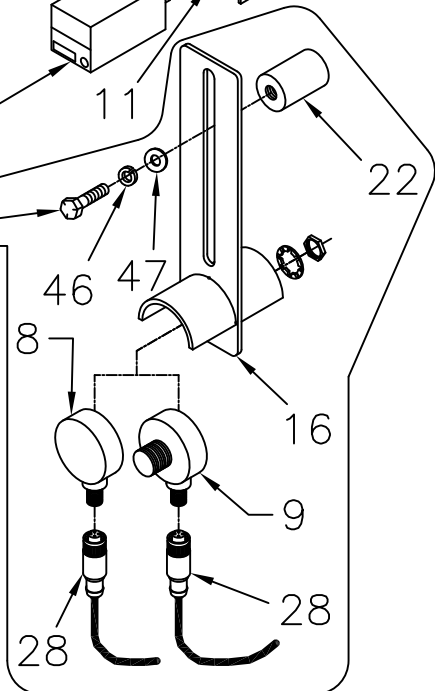
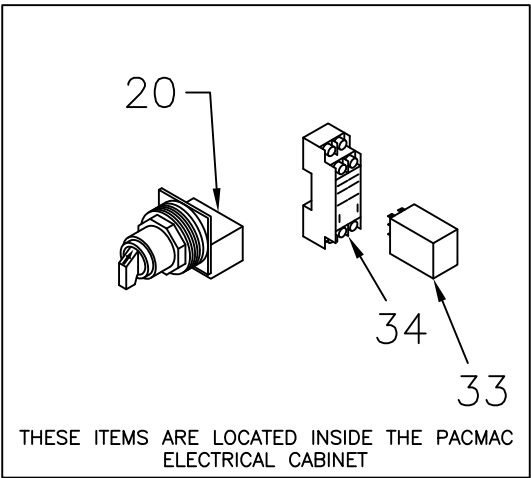
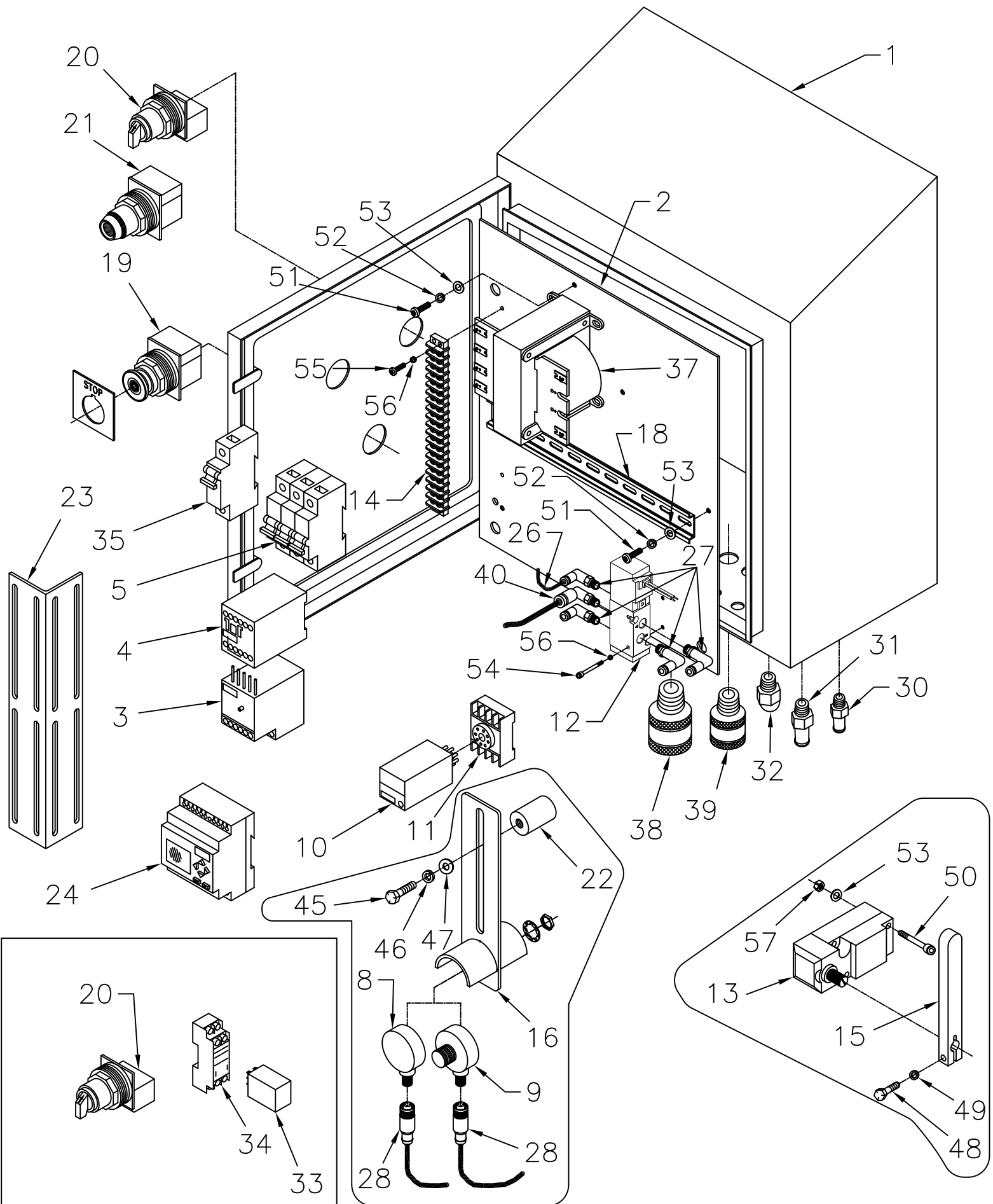
ITEM	PART NUMBER	DESCRIPTION	QTY
1	1589-0001SS	Mounting Bracket	1
2	1589-0003	Shaft	1
3	9589-0004SS	Bag Slide	1
4	9589-0007	Clamp Arm	2
5	9589-0010	Pivot Shaft	1
6	3/8-16X1 3/4HH	Hex Head Bolt	1
8	1/2-13X1 1/4HH	Hex Head Bolt	3
9	1/2-13X3/4SH	Socket Head Bolt	2
10	1/2FW	Flat Washer	2
11	3/8LW	Lock Washer	1
12	1/2LW	Lock Washer	6
13	1/2-13HN	Hex Nut	1
14	1/2-13X1 1/2HH	Hex Head Bolt	4

PACMAC, INCORPORATED
 MODEL 9500
 VERTICAL FORM, FILL
 AND SEAL MACHINE
 9590BTM CONVEYOR CONTROL ASSEMBLY (OPTIONAL)

ITEM	PART NUMBER	DESCRIPTION	QTY
1	9590-0001SS	ENCLOSURE	1
2	9590-0002SS	SUBPANEL	1
3	9590-0003	MOTOR OVERLOAD	1
4	9590-0004	MOTOR CONTACTOR	1
5	9590-0005	CIRCUIT BREAKER	1
8	9590-0008BTM	EMITTER	1
9	9590-0009BTM	RECEIVER	1
10	9590-0010	CONTROL RELAY	1
11	9590-0011	RELAY SOCKET	1
12	9590-0012	AIR VALVE	1
13	9590-0013	LIMIT SWITCH	2
14	9590-0014	TERMINAL BLOCK	1
15	9590-0015	SENSOR BAR	2
16	9590-0016	EYE BRACKET	2
18	9590-0018	DIN RAIL, 12"	1
19	9590-0019	E-STOP SWITCH	1
20	9590-0020	ROTARY SWITCH	2
21	9590-0021	PUSH BUTTON SWITCH	1
22	9590-0022	STANDOFF	2
23	9590-0023	LIMIT SWITCH BRACKET	2
24	9590-0024	PLC	1
26	9200-0039	¼" AIR TUBING	2'
27	9200-0046	TUBING CONNECTOR	4

PACMAC, INCORPORATED
 MODEL 9500
 VERTICAL FORM, FILL
 AND SEAL MACHINE
 9590BTM CONVEYOR CONTROL ASSEMBLY (OPTIONAL)

ITEM	PART NUMBER	DESCRIPTION	QTY
28	9200-0070	CABLE	2
29	9200-0096	3/8" AIR TUBING	1'
30	9216-0033	BULKHEAD FITTING	4
31	9216-0035	3/8" BULKHEAD FITTING	1
32	9216-0048	CORD GRIP	1
33	9218-0017	RELAY	1
34	9218-0028	RELAY SOCKET	1
35	9218-0062	220V BREAKER (2 AMP)	1
37	9232-0011	TRANSFORMER	1
38	9500-59	CORD GRIP	1
39	9500-81	CORD GRIP	4
40	9502-0062	TUBING CONNECTOR	1
45	3/8-16X1HH	HEX HEAD BOLT	2
46	3/8LW	LOCK WASHER	2
47	3/8FW	FLAT WASHER	2
48	¼-20X1HH	HEX HEAD BOLT	1
49	1/4LW	LOCK WASHER	1
50	10-32X1 1/2SH	PHILLIPS PAN HEAD SCREW	4
51	10-32X1/2PPH	PHILLIPS PAN HEAD SCREW	6
52	#10LW	LOCK WASHER	8
53	#10FW	FLAT WASHER	12
54	6-32X1SH	SOCKET HEAD BOLT	2
55	6-32X1/2PPH	PHILLIPS PAN HEAD SCREW	2
56	#6LW	LOCK WASHER	4
57	10-32LN	LOCK NUT	4



(OPTIONAL)



**1500 Electrical
Schematic Book
(V2021)**

1500 WIRE DIAGRAMS

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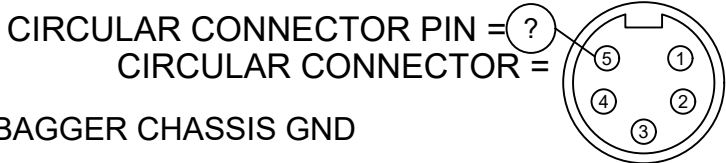
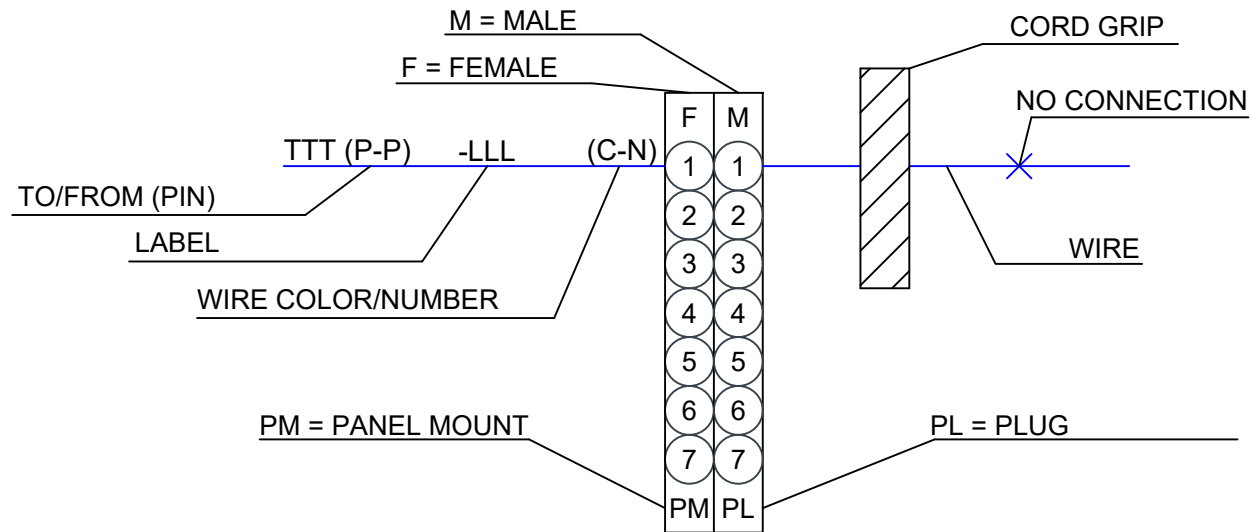
C. HATCHER

PG.	TITLE	DESCRIPTION	SECTION
001	LEGEND	SYMBOLS AND ABBREVIATIONS	GUIDE
002	SERVO DRIVE SWITCH SELECTIONS	W2/Z SWITCH SELECTIONS	GUIDE
003	CABLE ENTRY GUIDE	EXTERNAL CABLE LAYOUT	GUIDE
004	1500 BLOCK DIAGRAM	MACHINE BLOCK DIAGRAM	BLOCK DIAGRAMS
005	TEMP. CTRL. BLOCK DIAGRAM	OVERVIEW OF TEMP. CTRL. SCHEME	BLOCK DIAGRAMS
006	PRINTER BLOCK DIAGRAM	PRINTER BLOCK DIAGRAM	BLOCK DIAGRAMS
007	ULTRASONIC BLOCK DIAGRAM	ULTRASONIC BLOCK DIAGRAM	BLOCK DIAGRAMS
008	SERVO DRIVE BLOCK DIAGRAM	SERVO DRIVE BLOCK DIAGRAM	BLOCK DIAGRAMS
009	BUTTON BLOCK DIAGRAM	E-STOP, RESET, FILM POSITION	BLOCK DIAGRAMS
010	MAINS	AC MAINS DISCONNECT	AC SUPPLY
011	MAIN BREAKER	AC MAIN BREAKER	AC SUPPLY
012	AC BREAKERS (16-13)	BREAKERS 16-13	AC SUPPLY
013	AC BREAKERS (12-9)	BREAKERS 12-9	AC SUPPLY
014	AC BREAKERS (8-5)	BREAKERS 8-5	AC SUPPLY
015	AC BREAKERS (4-1)	BREAKERS 4-1	AC SUPPLY
016	MULTIZONE TEMPERATURE CONTROL	MULTIZONE TEMPERATURE CONTROL	TEMP. CONTROL
017	STANDARD TEMPERATURE CONTROL	STANDARD TEMPERATURE CONTROL	TEMP. CONTROL
018	DC BREAKER	COMPUTER BREAKER	DC SUPPLY
019	SELECTIVE POWER MODULE	CONTROL POWER PROTECTION	DC SUPPLY
020	DC SUPPLY (CONTROL)	POWER SUPPLY FOR CONTROL	DC SUPPLY
021	DC SUPPLY (COMPUTER)	POWER SUPPLY FOR HMI AND LIGHTS	DC SUPPLY
022	WORK LIGHTS	WORK LIGHT WIRING	LIGHTS
023	FILM DRIVE CONTACTORS	CONTACTOR WIRING	SAFETY SYSTEM
024	JAW DRIVE CONTACTORS	CONTACTOR WIRING	SAFETY SYSTEM
025	TRANSVERSE DRIVE CONTACTORS	CONTACTOR WIRING	SAFETY SYSTEM
026	RATIO DRIVE CONTACTORS	CONTACTOR WIRING	SAFETY SYSTEM
027	SAFETY PLC	SAFETY PLC WIRING	SAFETY SYSTEM
028	SAFETY PLC LADDER DIAGRAM	LADDER LOGIC FOR PLC	SAFETY SYSTEM
029	10W300 HMI CONTROL	HMI CONTROL WIRING	MACH. CONTROL
030	HMI CONTROL DETAILS	CONNECTOR DETAILS	MACH. CONTROL
031	MCR RELAY	MCR RELAY WIRING	MACH. CONTROL
032	CONTROL TERMINAL BLOCKS	24/24COM TERMINAL BLOCK WIRING	MACH. CONTROL
033	INPUT BOARD	INPUT BOARD WIRING	MACH. CONTROL
034	OUTPUT BOARD	OUTPUT BOARD WIRING	MACH. CONTROL
035	NETWORK SWITCH	MACHINE NETWORK WIRING	MACH. CONTROL
036	VERTICAL SEAL JUNCTION BOX	JUNCTION BOX WIRING	HEAT ZONES
037	VERT./ZIPPER HEATER ASSY	VERTICAL/ZIPPER HEAT ROD WIRING	HEAT ZONES
038	HORIZONTAL HEATER ASSY	HORIZONTAL HEAT ROD WIRING	HEAT ZONES
039	FILM SPLICE JUNCTION BOX	JUNCTION BOX WIRING	HEAT ZONES
040	FILM SPLICE HEATER ASSY	FILM SPICE HEAT ROD WIRING	HEAT ZONES
041	TD HEATER ASSY	TD HEAT ROD WIRING	HEAT ZONES
042	FILM SERVO DRIVE	FILM SERVO WIRING	SERVO CONTROL
043	JAW SERVO DRIVE	JAW SERVO WIRING	SERVO CONTROL
044	TRANSVERSE SERVO DRIVE	TRANSVERSE SERVO WIRING	SERVO CONTROL
045	RATIO SERVO DRIVE	RATIO SERVO WIRING	SERVO CONTROL
046	9518-0001D-20 U.S. POWER SUPPLY	ULTRASONIC WIRING	ULTRASONICS

047	9518-0001D-20V2 U.S. POWER SUPPLY	ULTRASONIC WIRING	ULTRASONICS
048	FRONT DOOR SENSOR	DOOR SENSOR WIRING	SENSORS
049	PROX. SENSORS	SENSOR WIRING	SENSORS
050	LOW FILM & EYE SENSORS	SENSOR WIRING	SENSORS
051	LOW AIR SENSOR	SENSOR WIRING	SENSORS
052	9218-0008UL2 E-STOP BUTTON	E-STOP WIRING	BUTTONS
053	1518-0008 E-STOP BUTTON	E-STOP WIRING	BUTTONS
054	RESET/START BUTTON	BUTTON WIRING	BUTTONS
055	FILM POSITION SWITCH	SWITCH WIRING	BUTTONS
056	LOWER JAW ASSY	VALVE WIRING	VALVES
057	REAR ENCLOSURE	VALVE WIRING	VALVES
058	TERMINAL BLOCKS (CHASSIS GROUND)	GROUND WIRING	MACHINE GROUND
059	EXTERNAL/SCALE INTERFACE TRM BLKS	BLUE TERMINAL BLOCK WIRING	EXTERNAL WIRING
060	SCALE DETAIL (BAGGER 24COM)	GENERIC SCALE WIRING	SCALE WIRING
061	SCALE DETAIL (BAGGER +24)	GENERIC SCALE WIRING	SCALE WIRING
062	SCALE DETAIL (SCALE 24COM)	GENERIC SCALE WIRING	SCALE WIRING
063	SCALE DETAIL (SCALE +24)	GENERIC SCALE WIRING	SCALE WIRING
064	SCALE DETAIL (OLD EAGLE)	SPECIFIC SCALE WIRING	SCALE WIRING
065	SCALE DETAIL (NEW EAGLE)	SPECIFIC SCALE WIRING	SCALE WIRING
066	SCALE DETAIL (TRIANGLE)	SPECIFIC SCALE WIRING	SCALE WIRING
067	SCALE DETAIL (9526 INFEED EYE ASSY)	SPECIFIC SCALE WIRING	SCALE WIRING
068	SCALE DETAIL (ISHIDA)	SPECIFIC SCALE WIRING	SCALE WIRING
069	SCALE DETAIL (YAMATA)	SPECIFIC SCALE WIRING	SCALE WIRING
070	SCALE DETAIL (MAREL)	SPECIFIC SCALE WIRING	SCALE WIRING
071	SCALE DETAIL (9590BTM CONV. CTRL.)	SPECIFIC SCALE WIRING	SCALE WIRING
072	NORWOOD PRINTER	NORWOOD PRINTER WIRING	PRINTER WIRING
073	MARKEM PRINTERS	MARKEM PRINTER WIRING	PRINTER WIRING
074	BELL-MARK PRINTERS	BELL-MARK PRINTER WIRING	PRINTER WIRING
075	GAS FLUSH FILTER ASSY	GAS FLUSH VALVE FILTER WIRING	MISCELLANEOUS

WIRE COLOR CHART

- BK = BLACK
- BN = BROWN
- R = RED
- O = ORANGE
- Y = YELLOW
- GN = GREEN
- BU = BLUE
- V = VIOLET
- GY = GREY
- W = WHITE
- PK = PINK
- LT. BN = LIGHT BROWN
- DK. BN = DARK BROWN
- SH = SHIELD W/ HEAT SHRINK



= BAGGER CHASSIS GND



= MASTER CONTROL RELAY



= PRODUCT ARRIVAL RELAY



= GAS FLUSH RELAY



= SCALE OVERLOAD RELAY



= LED



= VALVE



= MOTOR

= F. QUICK DIS.

= M. QUICK DIS.

= BREAKER

= FUSE



= BACK TO GRID SELECT



= FULL VIEW



= 5 STATION LEVER NUT



= 3 STATION LEVER NUT



= 2 STATION LEVER NUT

OR = NORMALLY CLOSED CONTACT

OR = NORMALLY OPEN CONTACT

= COIL

= PUSH BUTTON

REVISIONS

NC	INITIAL RELEASE	3.3.21	CH
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1500 WIRE DIAGRAMS

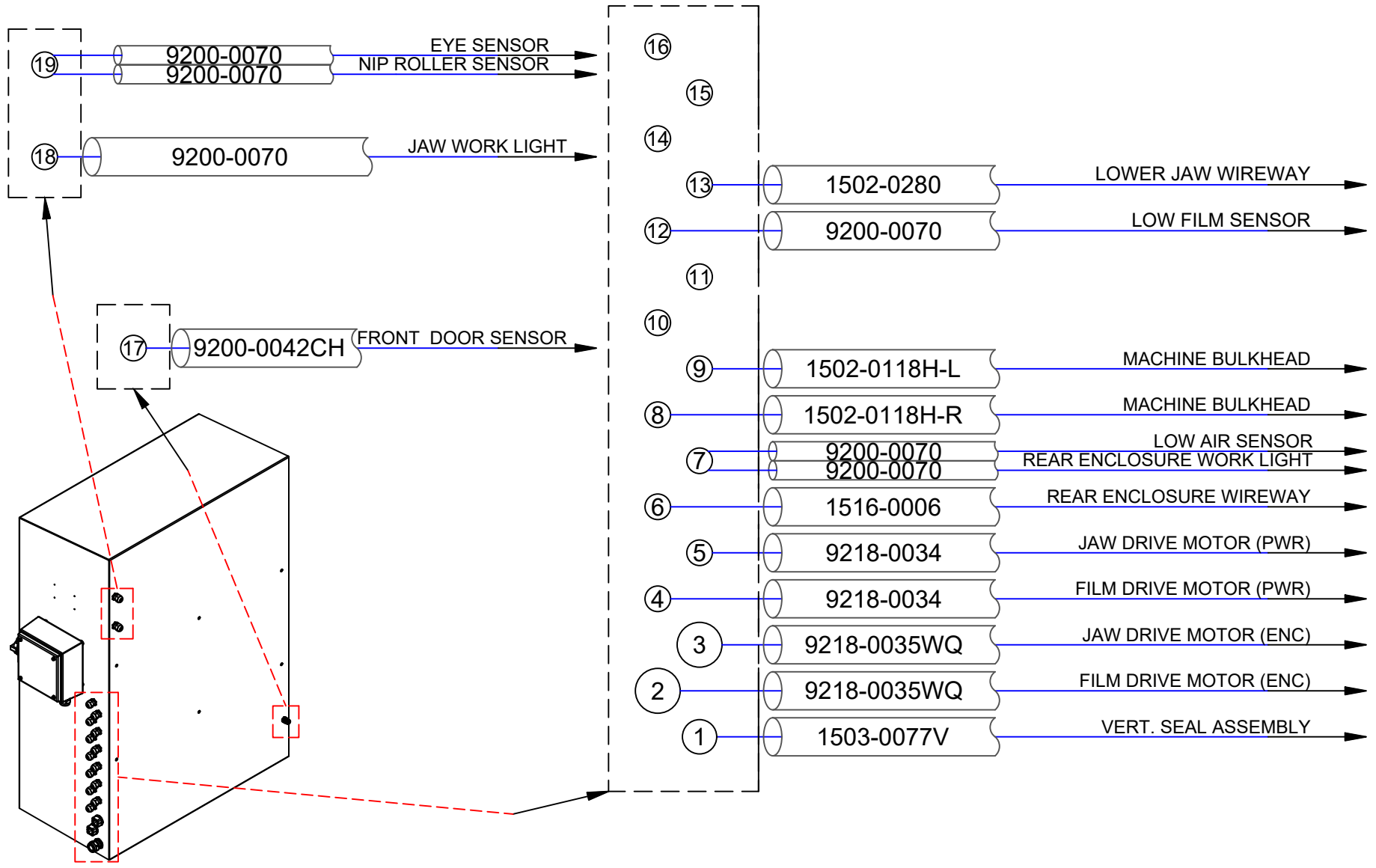
NC	LEGEND	3.3.21	CH
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SELECTION	FUNCTION	MOTOR MODEL	ROTATION	WQ EQUIVALENT
1	FD ONLY	9201-0001H	CLOCKWISE	9218-0002WQ
2	FD-MUL	9201-0001H	CLOCKWISE	9518-0002M
3	FD ONLY	9201-0001H	CNTR-CLOCKWISE	2018-0002WQ
4	FD-MUL	9201-0001H	CNTR-CLOCKWISE	2018-0002M
5	FD ONLY	9201-0001W	CLOCKWISE	9218-0002W
6	JD	9502-0215	CLOCKWISE	9502-0216
7	JD	9201-0001H	CLOCKWISE	9502-0216H
8	JD	9502-0215EX	CLOCKWISE	9502-0216EX
9	TD	9568-0004	CLOCKWISE	9568-0001WQ
AUX (DEFAULT)	TD	9502-0215EX	CLOCKWISE	9568-0001EX

**AUX CAN BE CONFIGURED WITH SOFTWARE SUPPORT PROGRAM.
SEE "HOW TO PROGRAM AUX SETTING" IN USER MANUAL.**

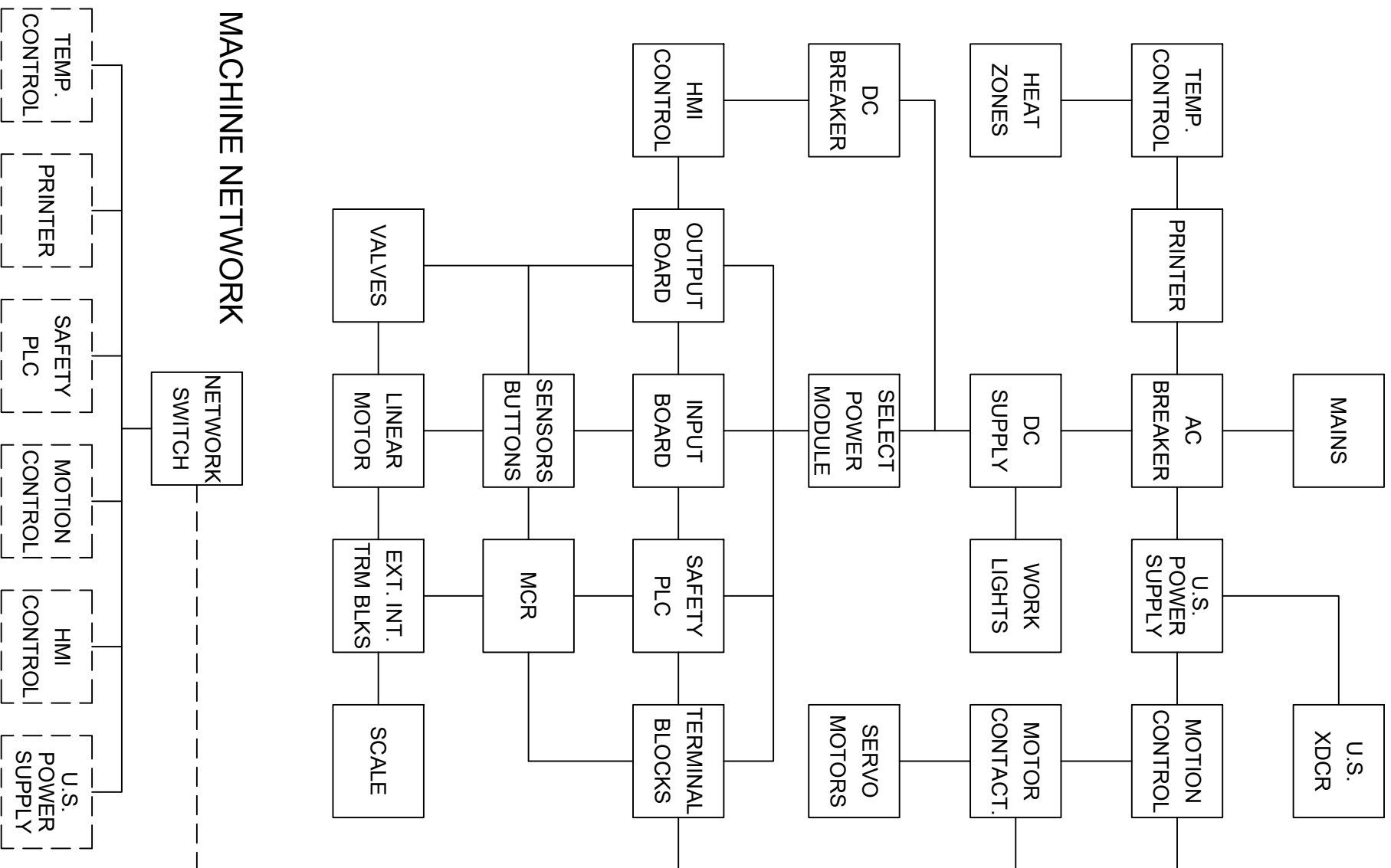
REVISIONS

1500 WIRE DIAGRAMS



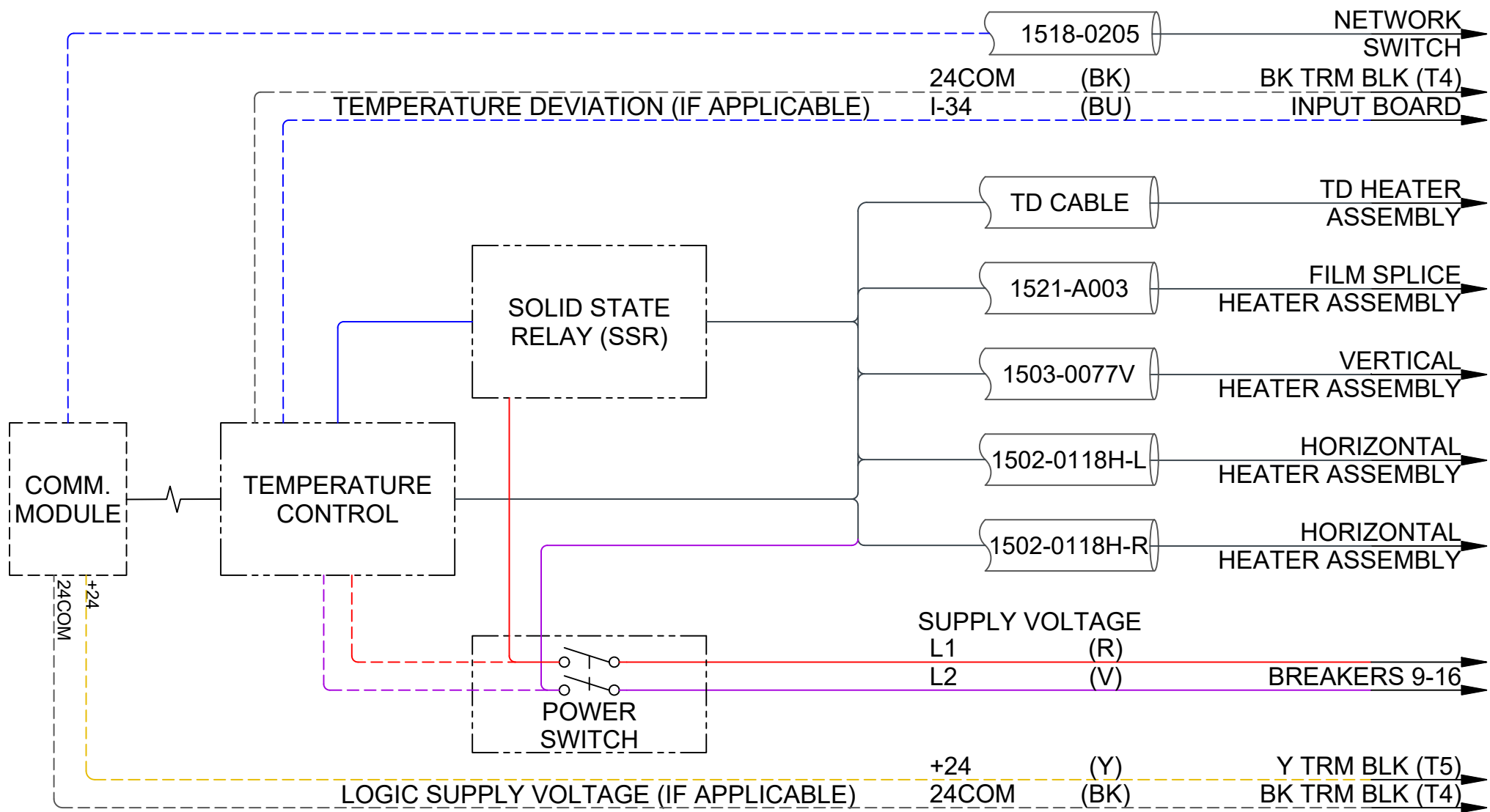
REVISIONS			
NC	INITIAL RELEASE	3.3.21	CH

1500 WIRE DIAGRAMS			
NC	CABLE ENTRY GUIDE	3.3.21	CH



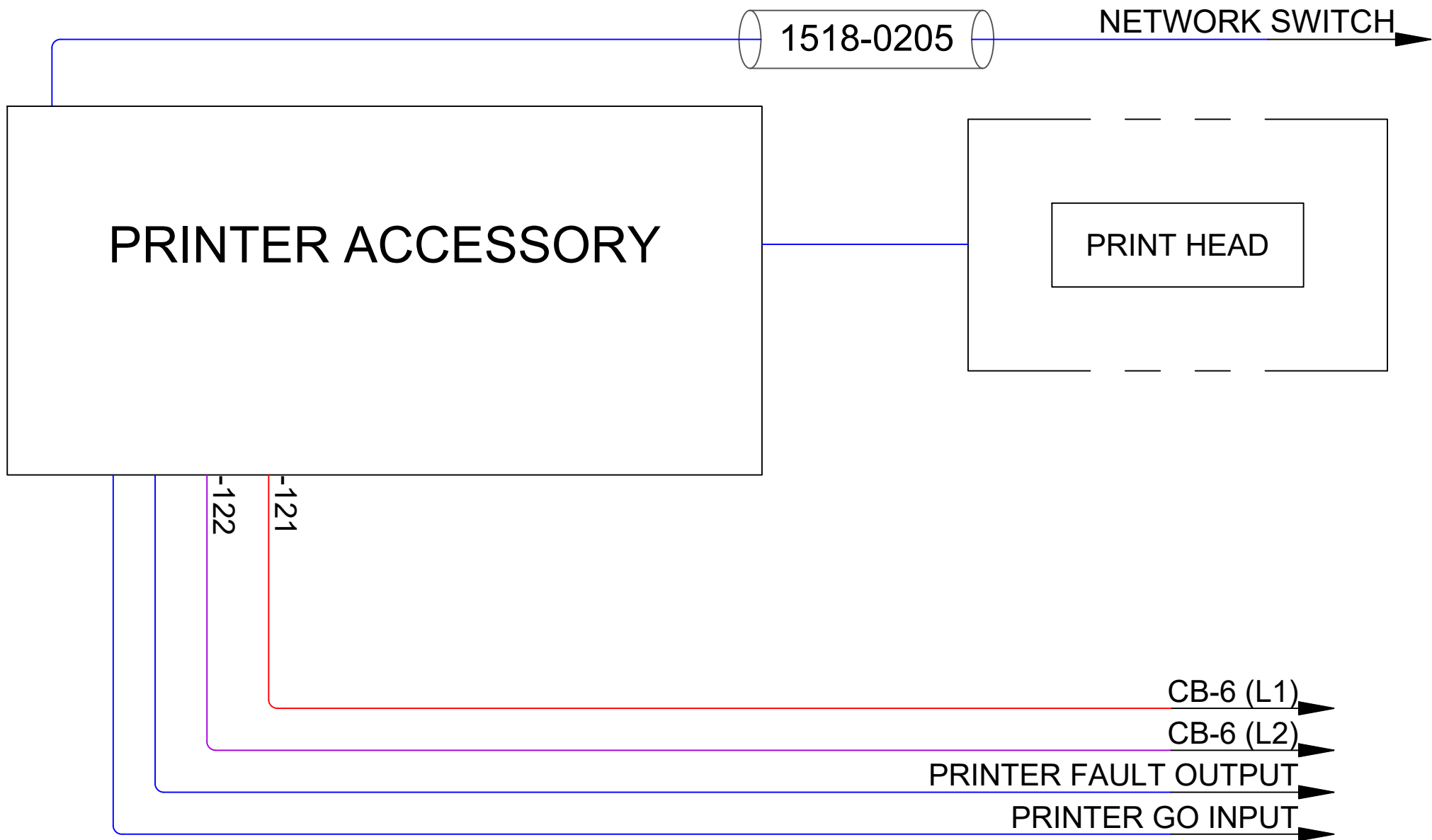
MACHINE NETWORK

NETWORK SWITCH



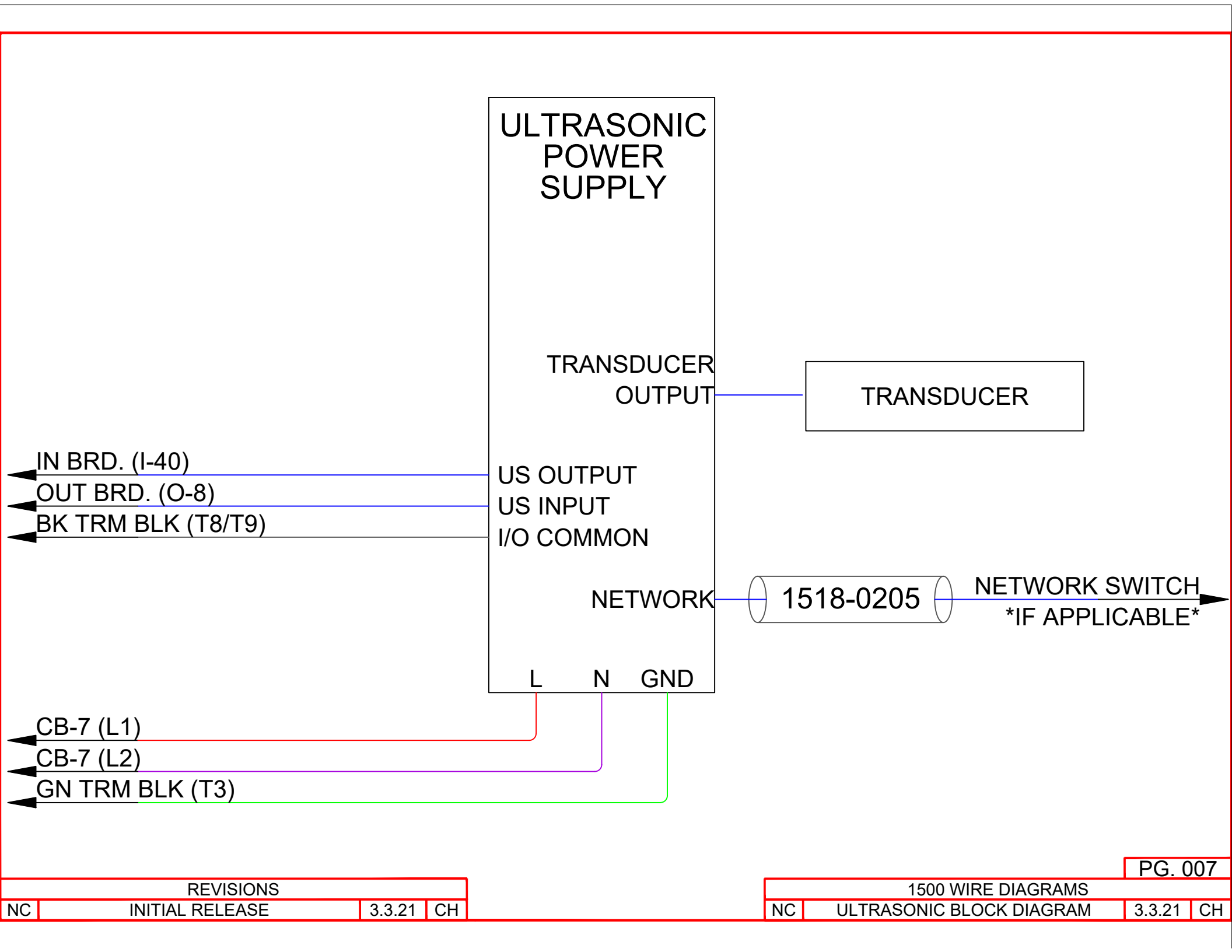
REVISIONS			
NC	INITIAL RELEASE	3.3.21	CH

1500 WIRE DIAGRAMS			
NC	TEMP. CTRL. BLOCK DIAGRAM	3.3.21	CH



REVISIONS			
NC	INITIAL RELEASE	3.3.21	CH

1500 WIRE DIAGRAMS			
NC	PRINTER BLOCK DIAGRAM	3.3.21	CH



ULTRASONIC
POWER
SUPPLY

TRANSDUCER
OUTPUT

TRANSDUCER

IN BRD. (I-40)
OUT BRD. (O-8)
BK TRM BLK (T8/T9)

US OUTPUT
US INPUT
I/O COMMON

NETWORK

1518-0205

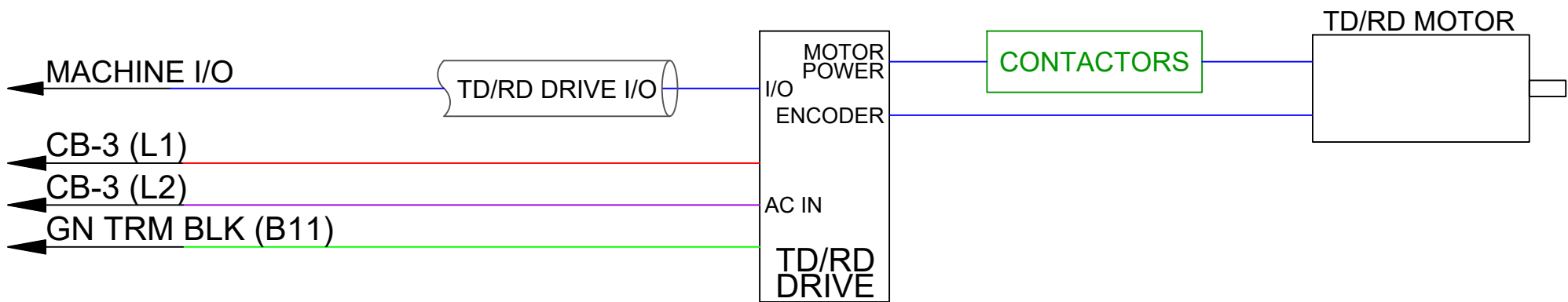
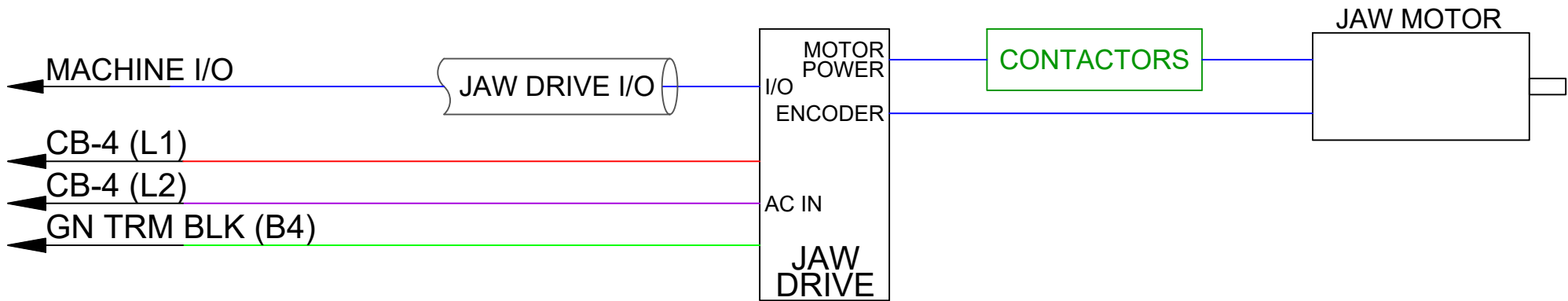
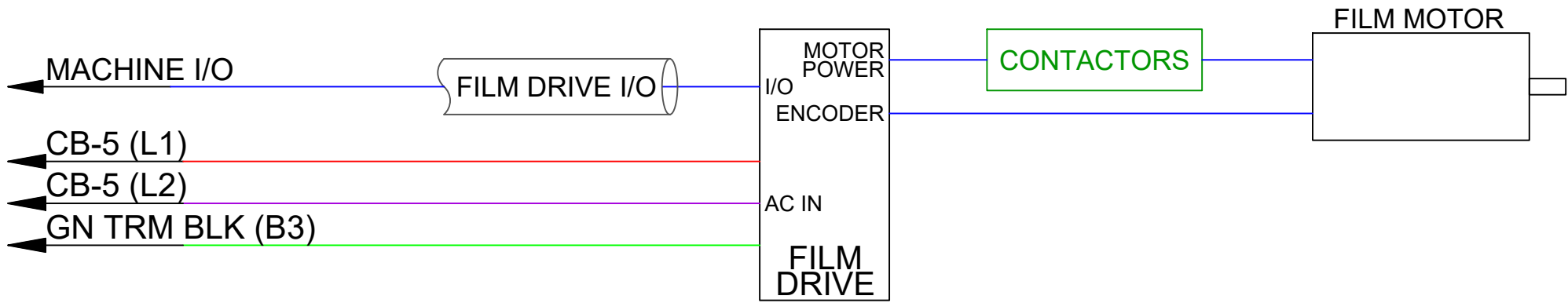
NETWORK SWITCH
IF APPLICABLE

L N GND

CB-7 (L1)
CB-7 (L2)
GN TRM BLK (T3)

REVISIONS			
NC	INITIAL RELEASE	3.3.21	CH

1500 WIRE DIAGRAMS			
NC	ULTRASONIC BLOCK DIAGRAM	3.3.21	CH

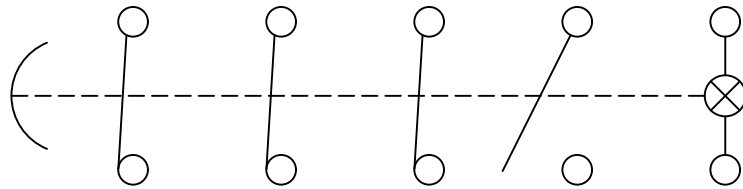


REVISIONS			
NC	INITIAL RELEASE	3.3.21	CH

1500 WIRE DIAGRAMS			
NC	SERVO DRIVE BLOCK DIAGRAM	3.3.21	CH

E-STOP BUTTON

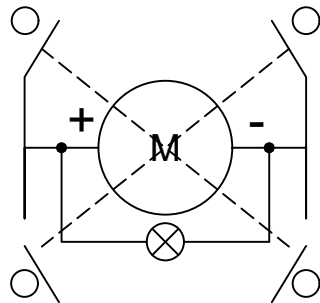
SEE E-STOP BUTTON CONFIGURATION FOR SPECIFIC MODEL WIRING



IN/24	(Y)	IN BRD. (I-11)
24COM	(BK)	BK TRM BLK (T2)
I-12	(BU)	IN BRD. (I-12)
SAFE-IO1	(BU)	SAFE PLC (IO1)
SAFE-IN1	(BU)	SAFE PLC (IN1)
SAFE-IN2	(BU)	SAFE PLC (IN2)

FILM POSITION SWITCH

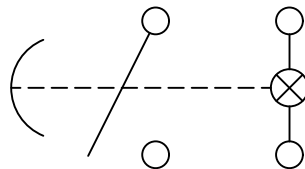
SEE FP SWITCH CONFIGURATION FOR SPECIFIC MODEL WIRING



+24	(Y)	Y TRM BLK (B4)
24COM	(BK)	BK TRM BLK (B7)
FP(+)	(BU)	1516-0006 (W)
FP(-)	(BU)	1516-0006 (DK. BN)

RESET/START BUTTON

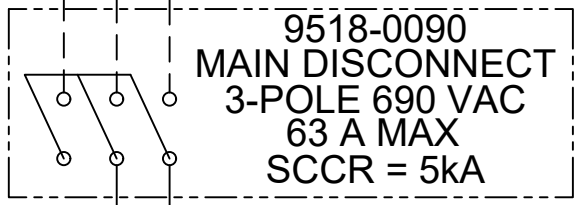
SEE RESET BUTTON CONFIGURATION FOR SPECIFIC MODEL WIRING



24COM	(BK)	BK TRM BLK (T3)
I-22	(BU)	IN BRD. (I-22)
O-38	(BU)	OUT BRD. (O-38)

1518-0100
EXTERNAL DISCONNECT BOX

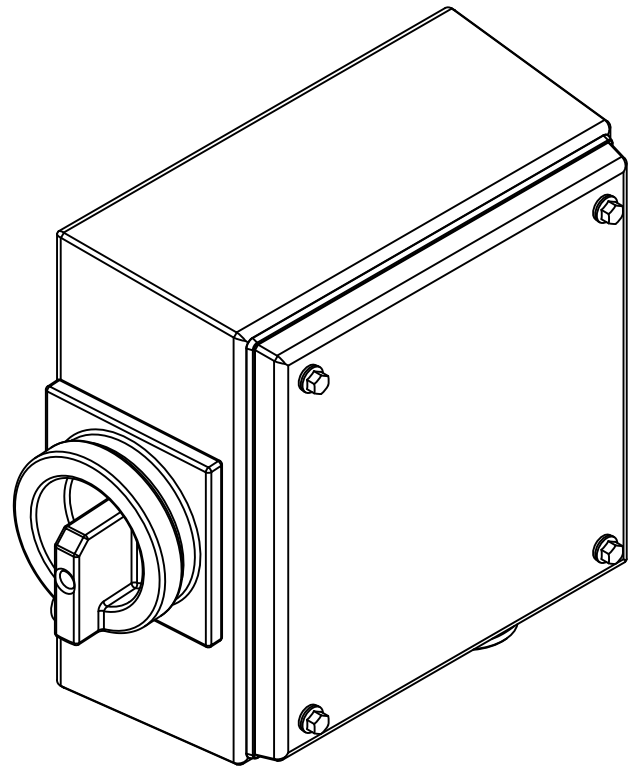
FIELD WIRING
208-240 VAC
SINGLE PHASE



GND

L2
L1

(BK)
(BK)
(GN)



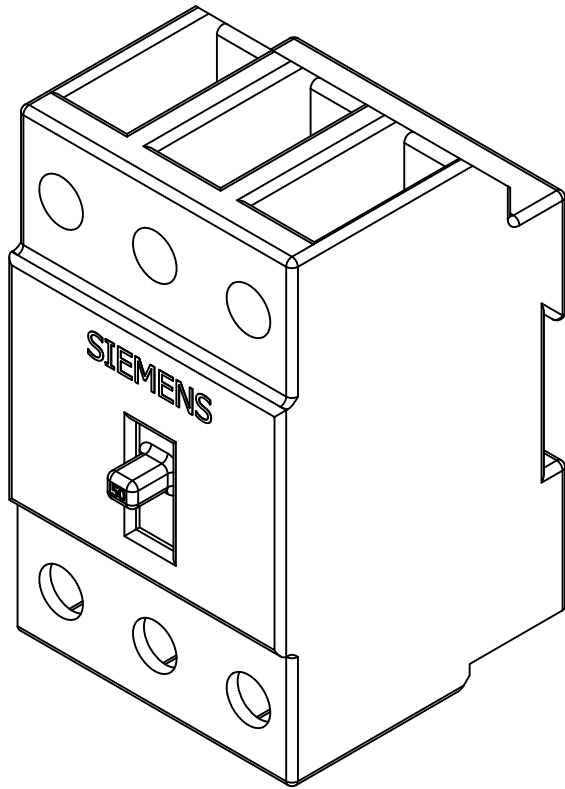
MAIN BREAKER (L1)
MAIN BREAKER (L2)
SUBPANEL GND

REVISIONS

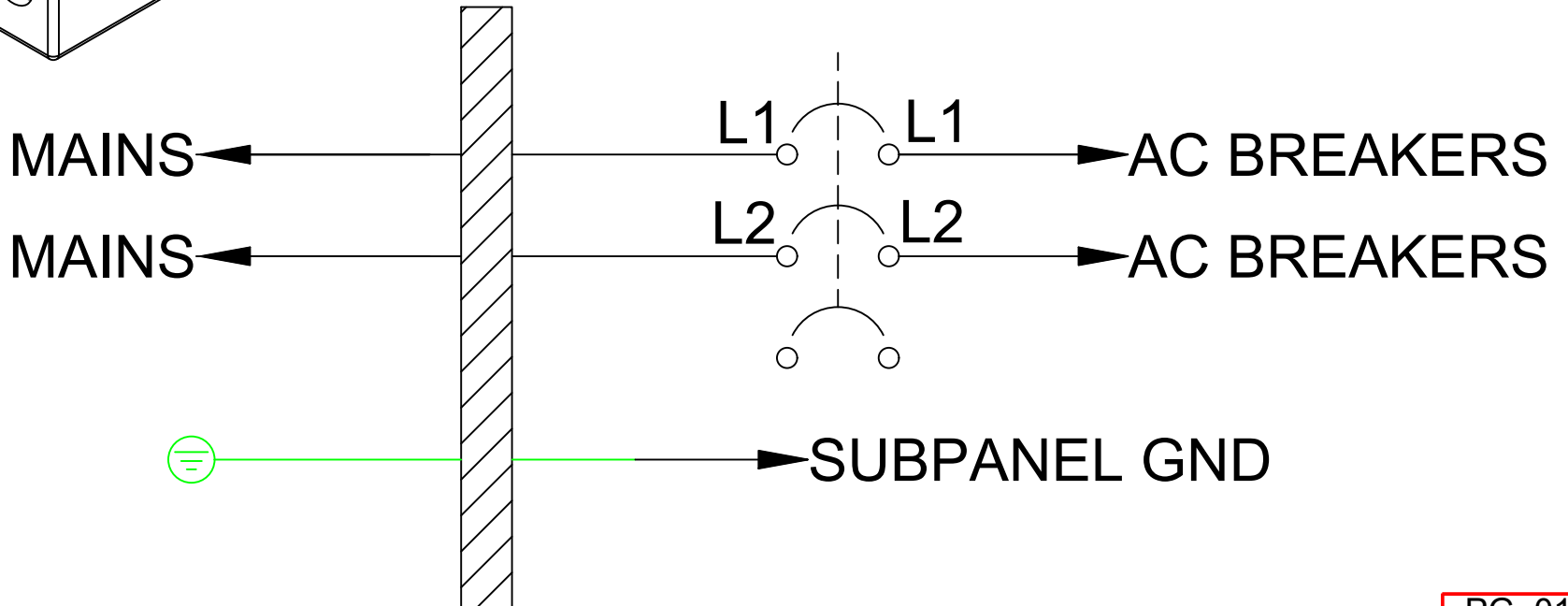
NC	INITIAL RELEASE	3.3.21	CH
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1500 WIRE DIAGRAMS

NC	MAINS	3.3.21	CH
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9518-0091
50 A MAIN BREAKER
3-POLE 480Y / 277 VAC
TYPE UL 489



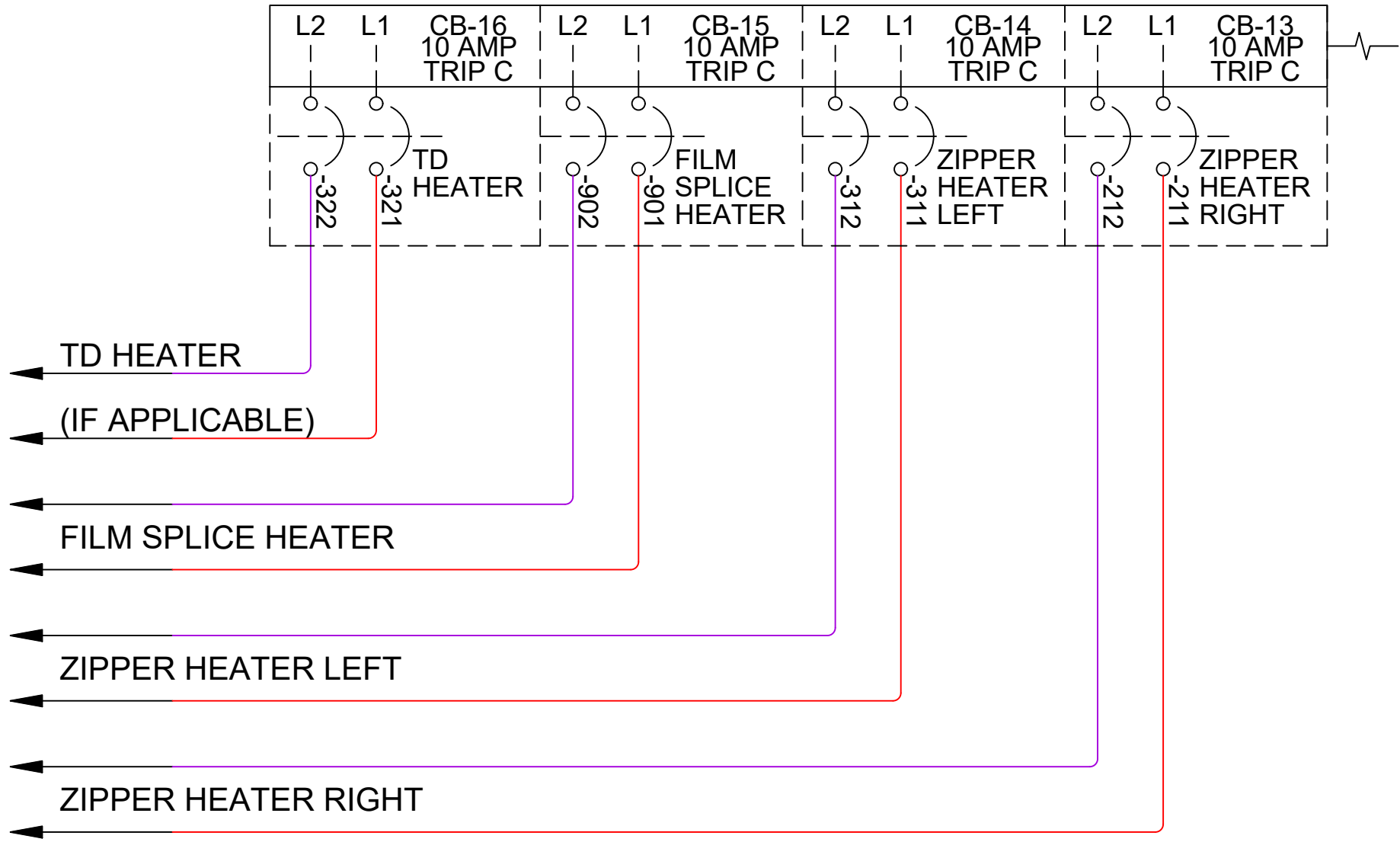
REVISIONS

NC	INITIAL RELEASE	3.3.21	CH
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1500 WIRE DIAGRAMS

NC	MAIN BREAKER	3.3.21	CH
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9218-0073UL-18 18 PIN BUS BAR

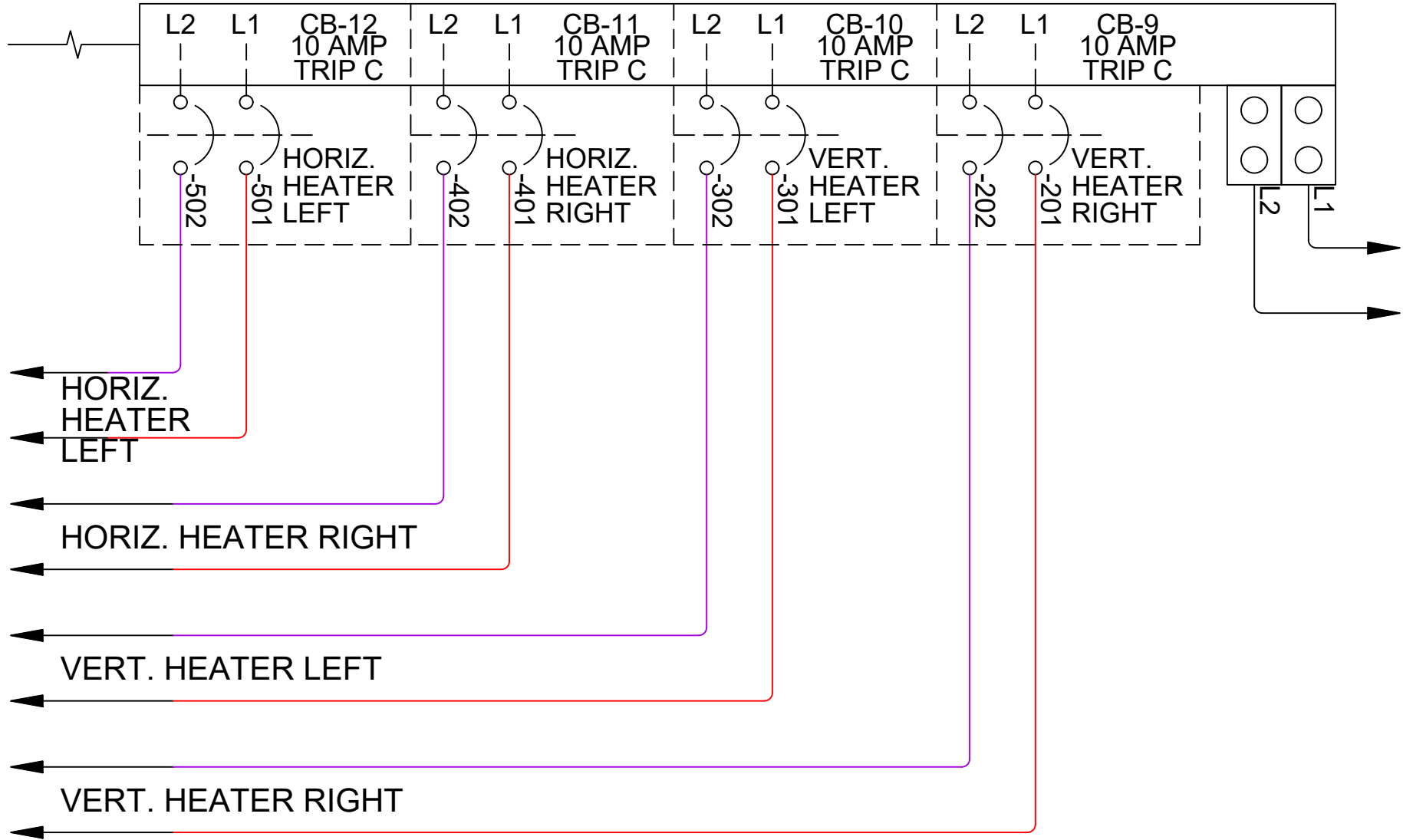


PART NUMBER	SIZE	TRIP	USED ON
9200-0082CUL 10 A BREAKER	10 A	C	CB-16/13

REVISIONS			
NC	INITIAL RELEASE	3.3.21	CH

1500 WIRE DIAGRAMS			
NC	AC BREAKER (16-13)	3.3.21	CH

9218-0073UL-18 18 PIN BUS BAR

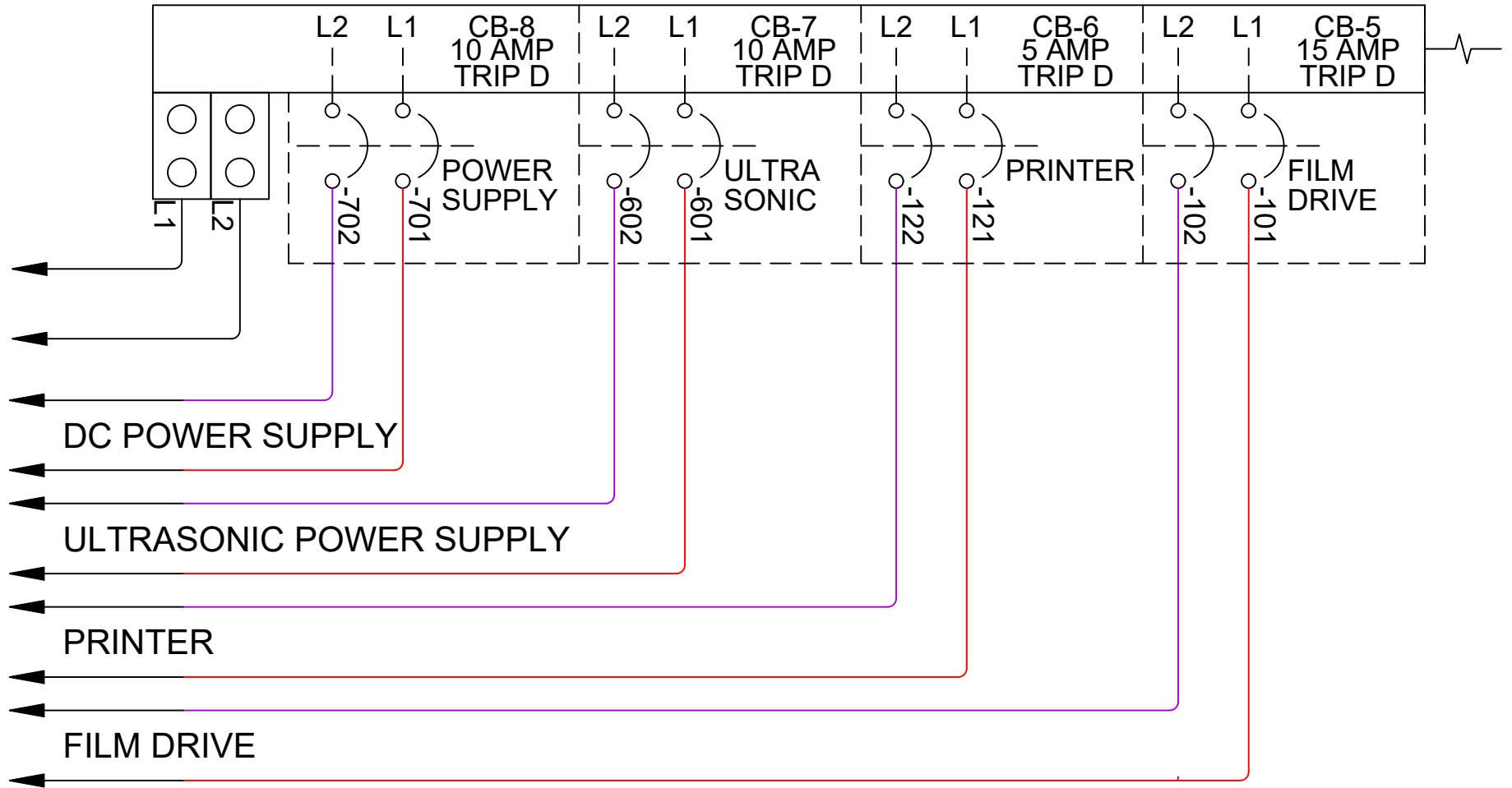


PART NUMBER	SIZE	TRIP	USED ON
9200-0082CUL 10 A BREAKER	10 A	C	CB-12/9

REVISIONS			
NC	INITIAL RELEASE	3.3.21	CH

1500 WIRE DIAGRAMS			
NC	AC BREAKER (12-9)	3.3.21	CH

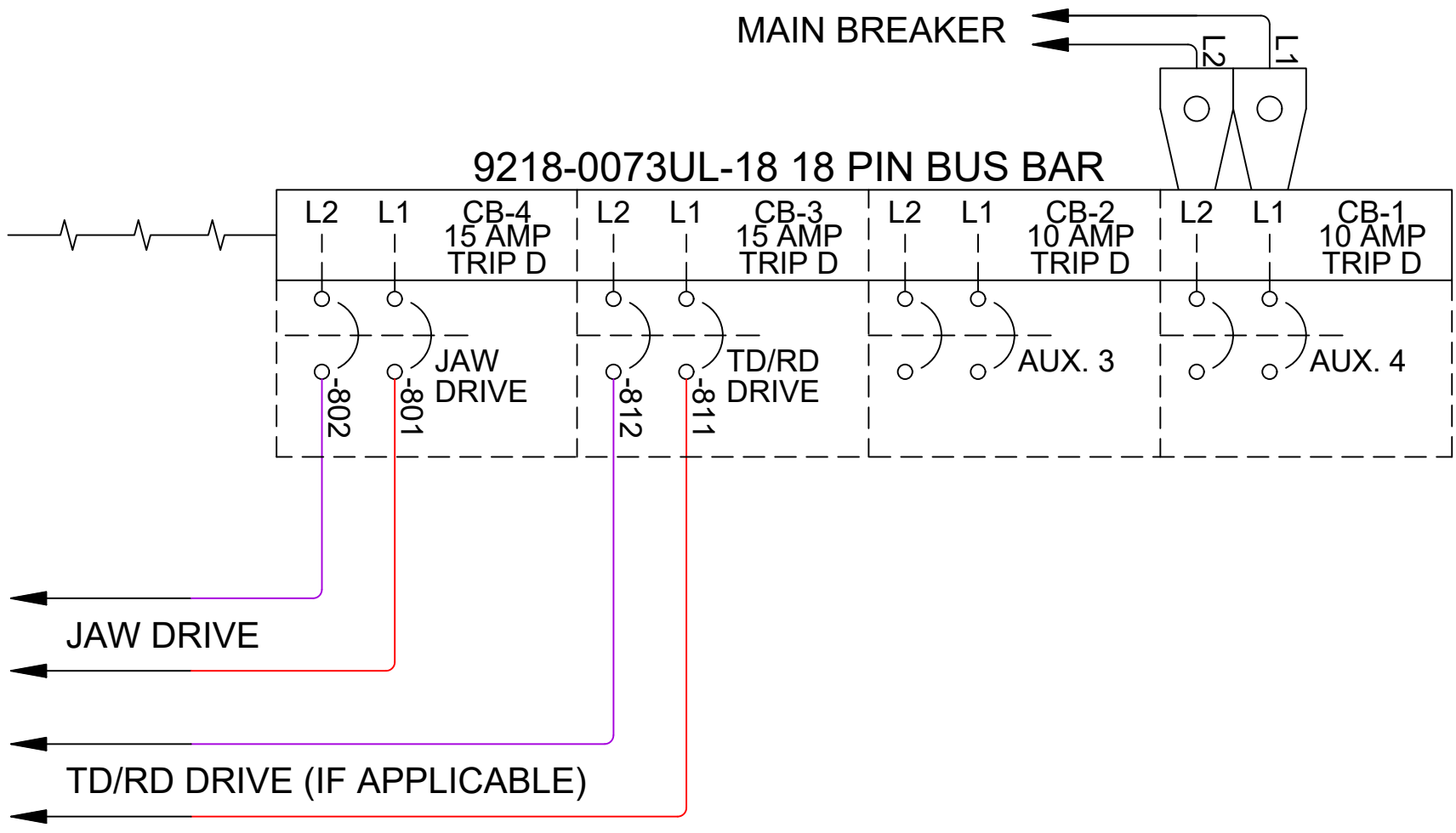
9218-0073UL-18 18 PIN BUS BAR



PART NUMBER	SIZE	TRIP	USED ON
9200-0082DUL 10 A BREAKER	10 A	D	CB-7/8
9200-0065DUL 5 A BREAKER	5 A	D	CB-6
9200-0064DUL 15 A BREAKER	15 A	D	CB-5

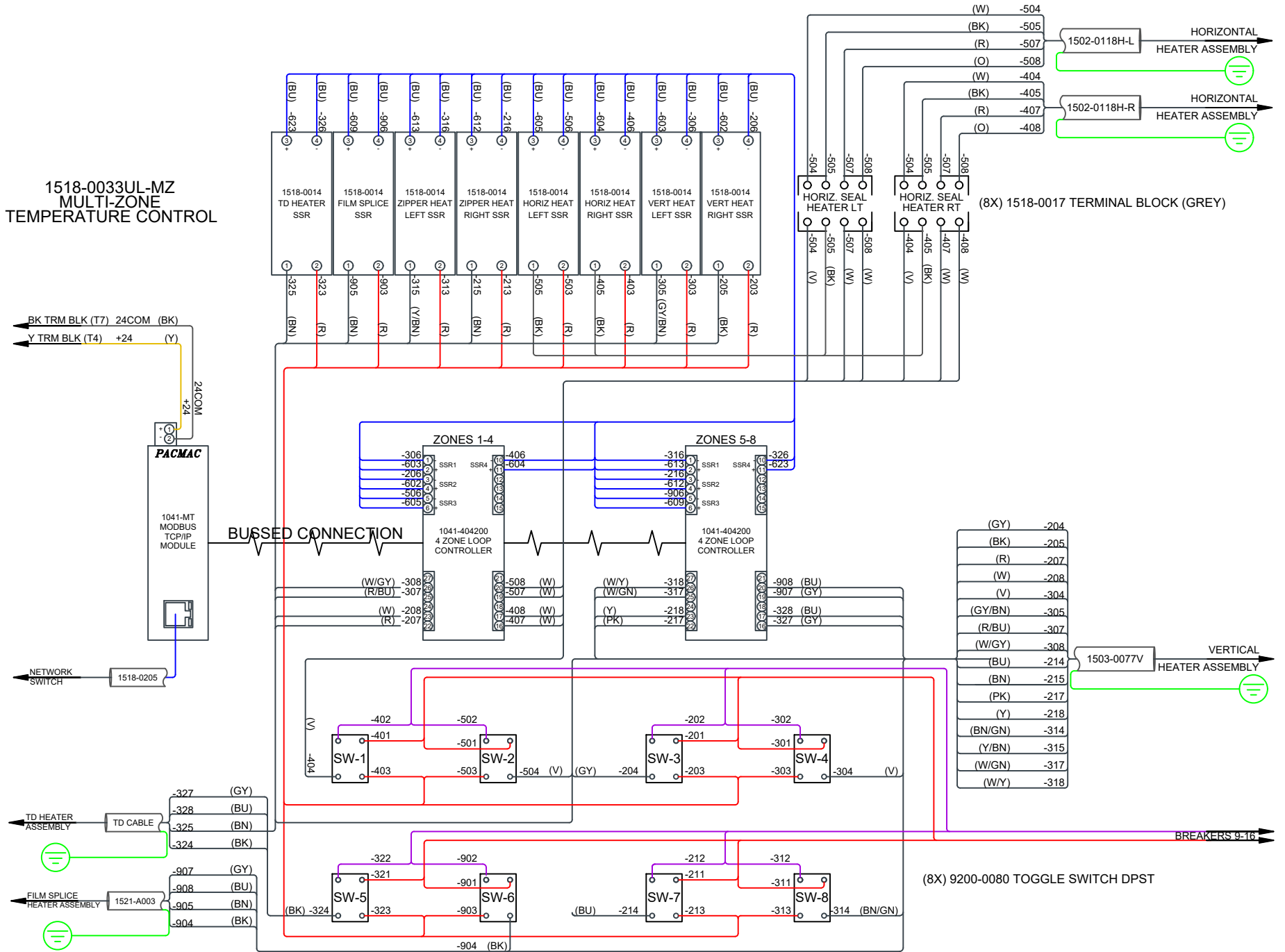
REVISIONS			
NC	INITIAL RELEASE	3.3.21	CH

1500 WIRE DIAGRAMS			
NC	AC BREAKER (8-5)	3.3.21	CH



PART NUMBER	SIZE	TRIP	USED ON
9200-0082DUL 10 A BREAKER	10 A	D	CB-2/1
9200-0064DUL 15 A BREAKER	15 A	D	CB-4/3

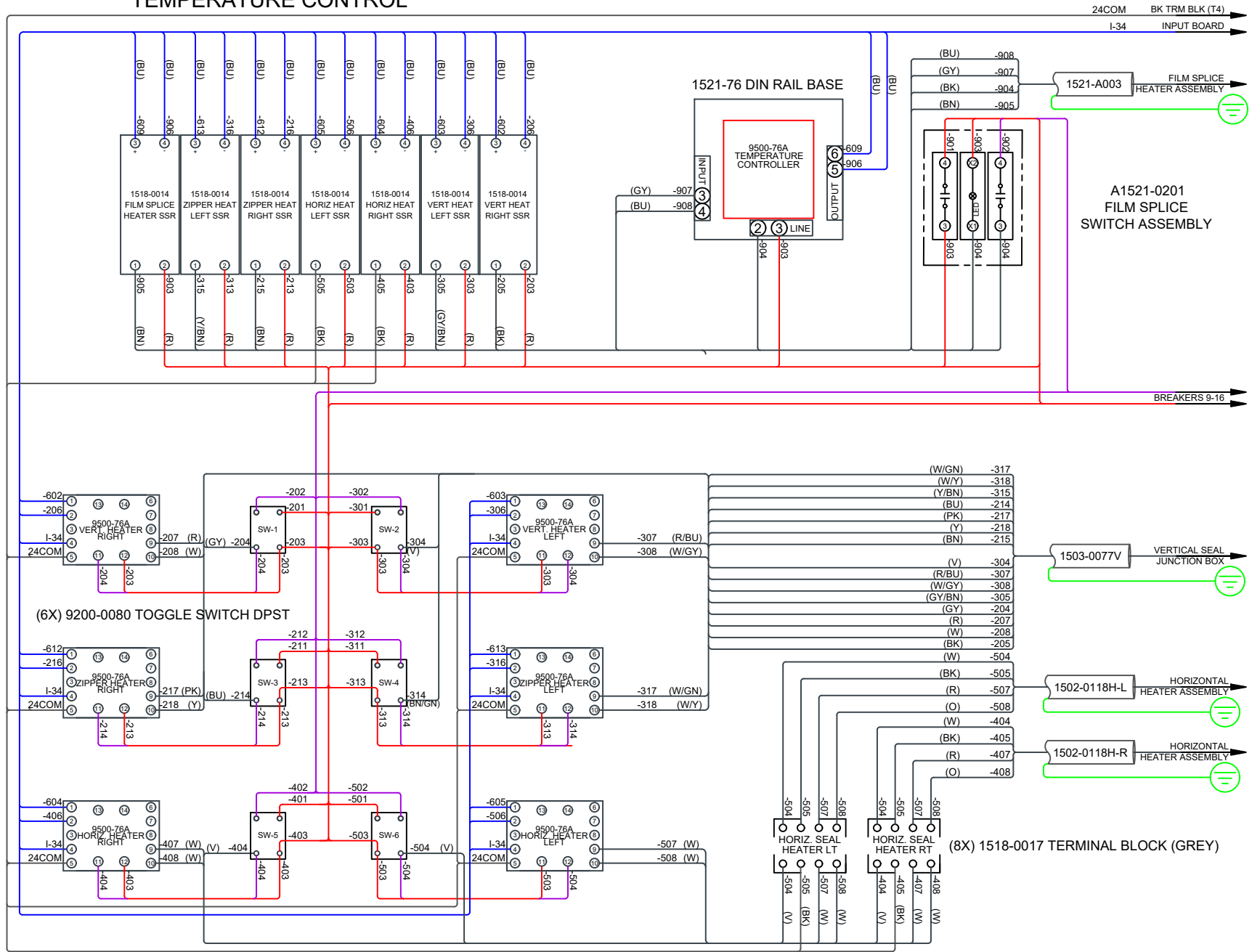
1518-0033UL-MZ MULTI-ZONE TEMPERATURE CONTROL



REVISIONS			
NC	INITIAL RELEASE	3.3.21	CH

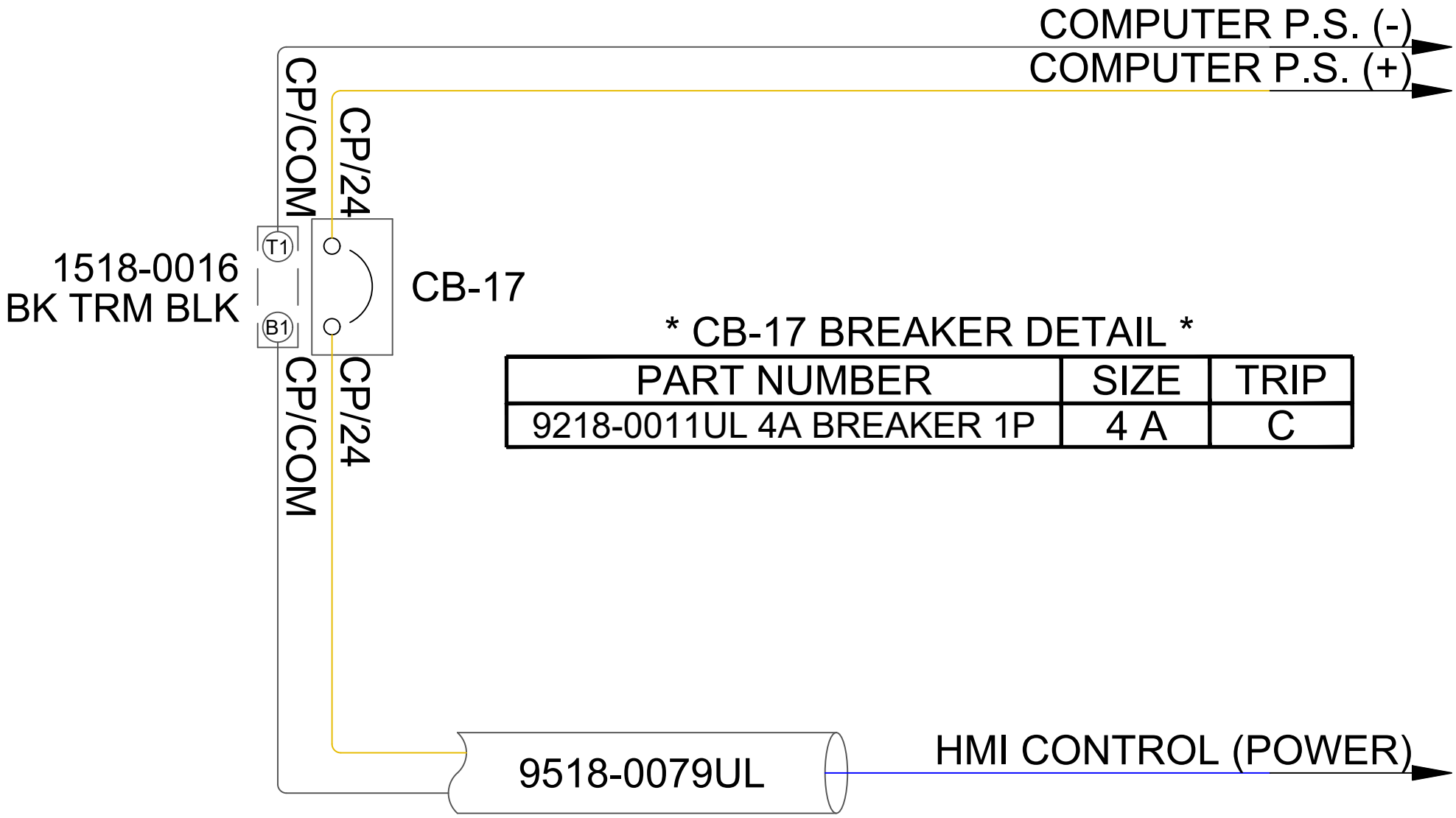
1500 WIRE DIAGRAMS			
NC	MULTIZONE TEMPERATURE CONTROL	3.3.21	CH

1518-0033UL TEMPERATURE CONTROL



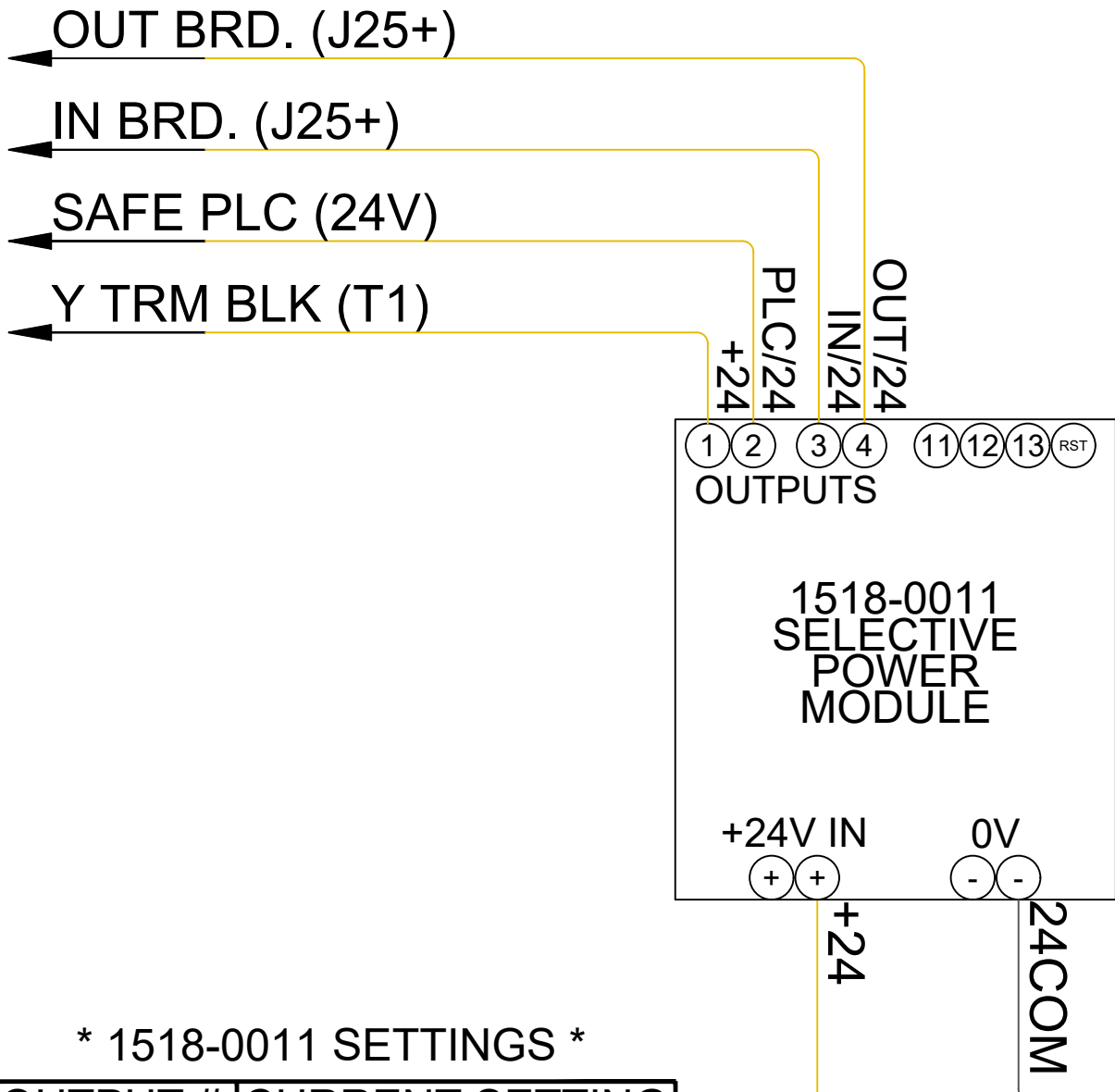
REVISIONS			
NC	INITIAL RELEASE	3.3.21	CH

1500 WIRE DIAGRAMS			
NC	STANDARD TEMPERATURE CONTROL	3.3.21	CH



* CB-17 BREAKER DETAIL *

PART NUMBER	SIZE	TRIP
9218-0011UL 4A BREAKER 1P	4 A	C

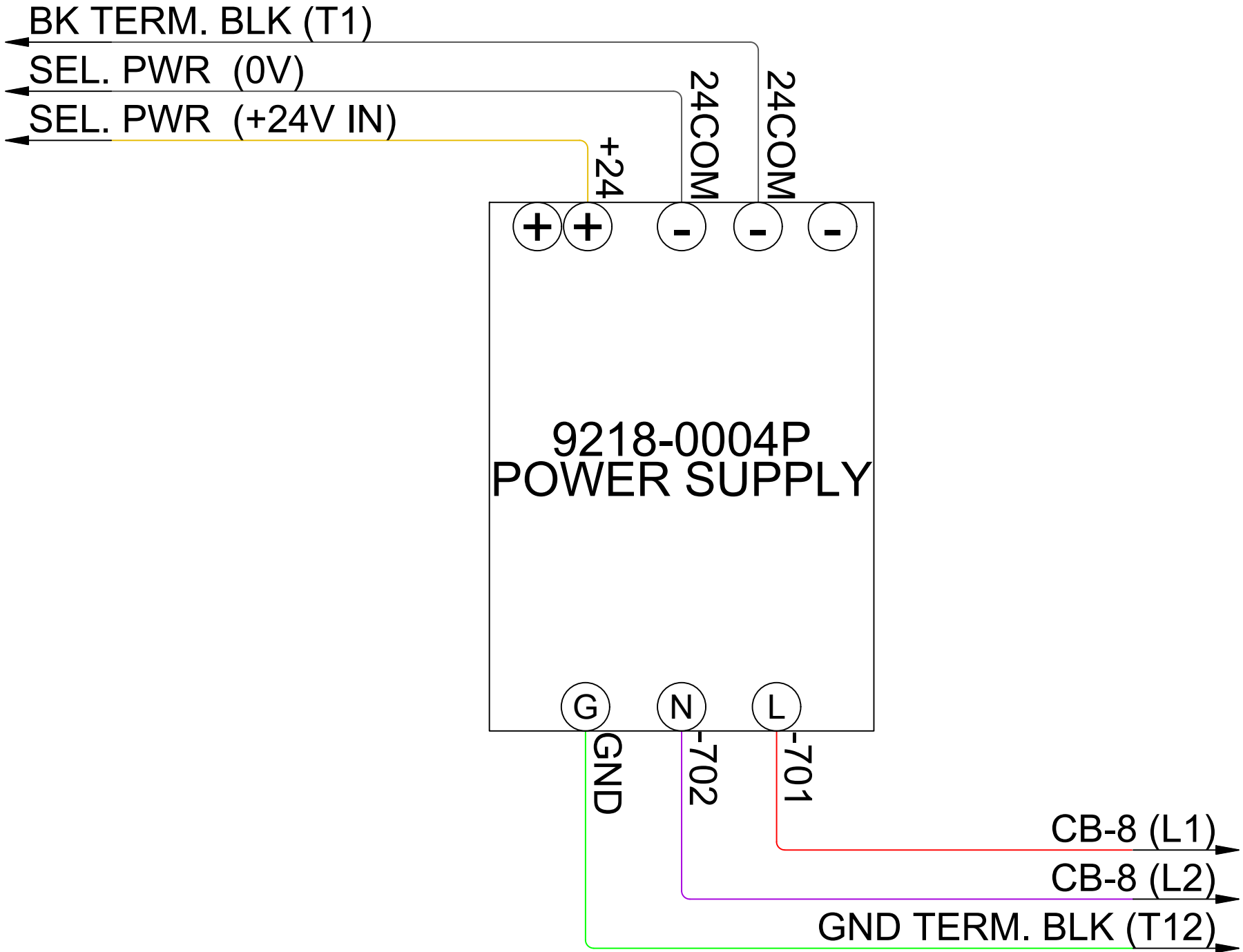


* 1518-0011 SETTINGS *

OUTPUT #	CURRENT SETTING
1	7 A
2	3 A
3	3 A
4	3 A

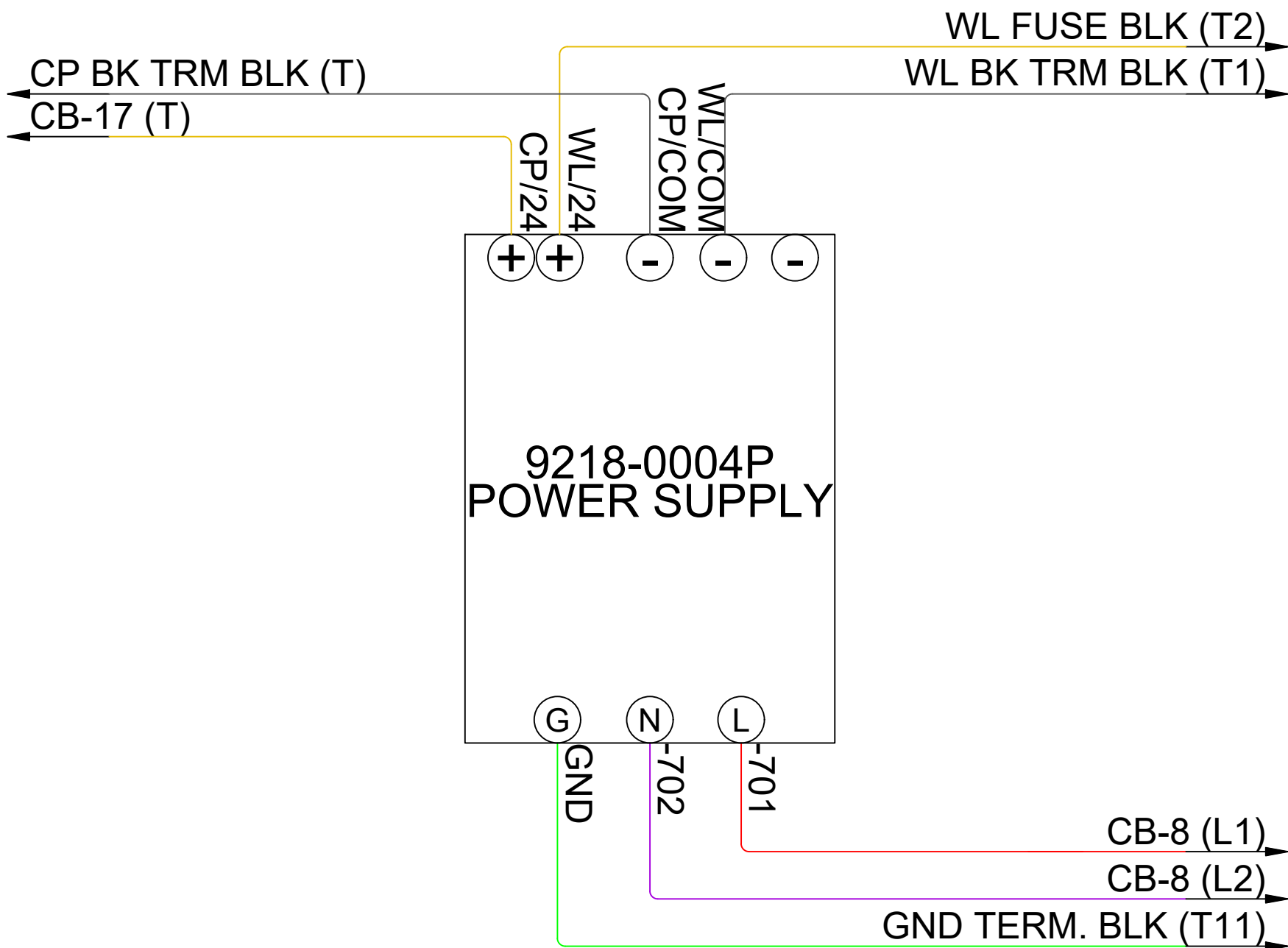
CONTROL P.S. (-) →

CONTROL P.S. (+) →



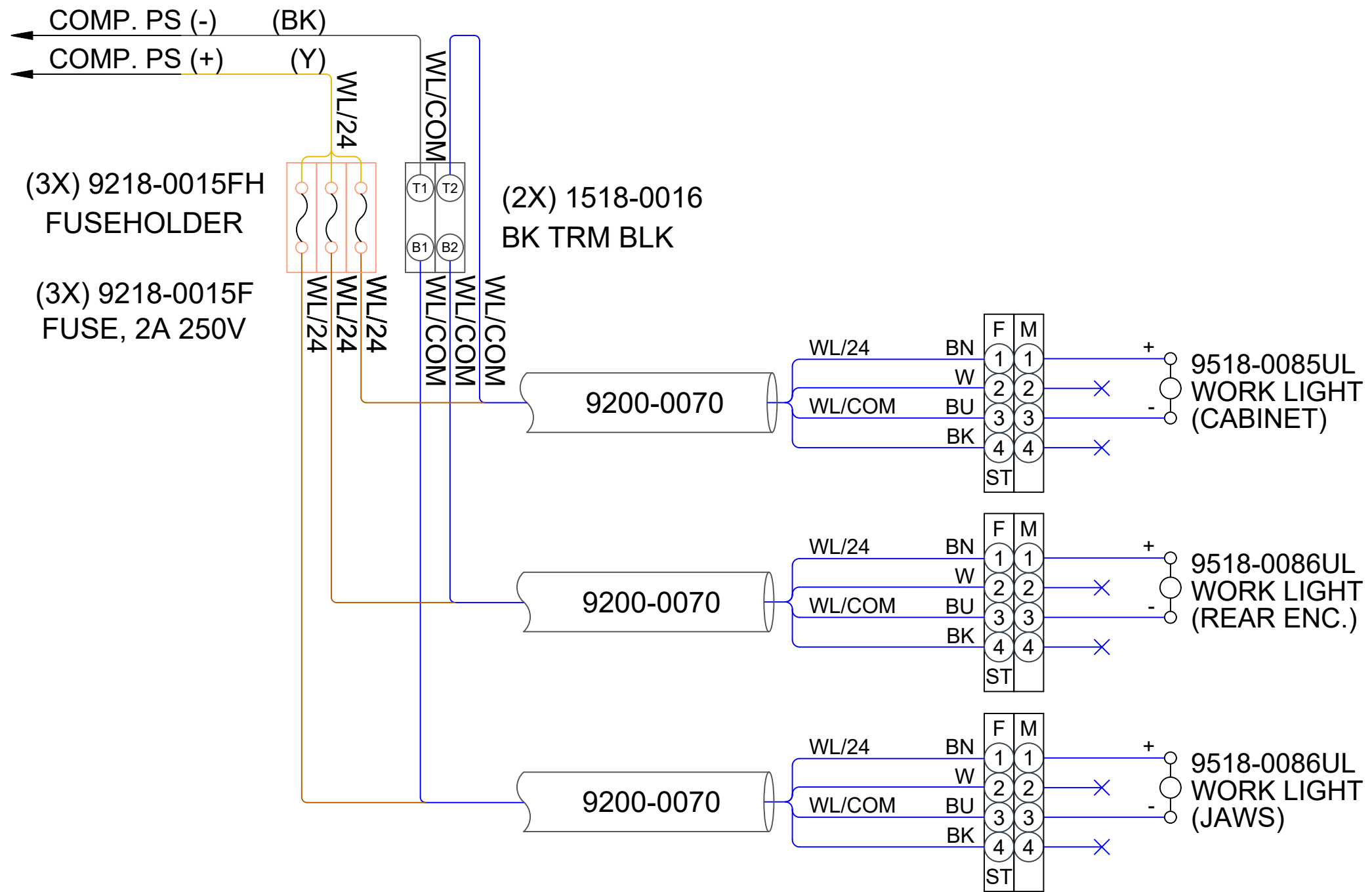
REVISIONS			
NC	INITIAL RELEASE	3.3.21	CH

1500 WIRE DIAGRAMS			
NC	DC SUPPLY (CONTROL)	3.3.21	CH



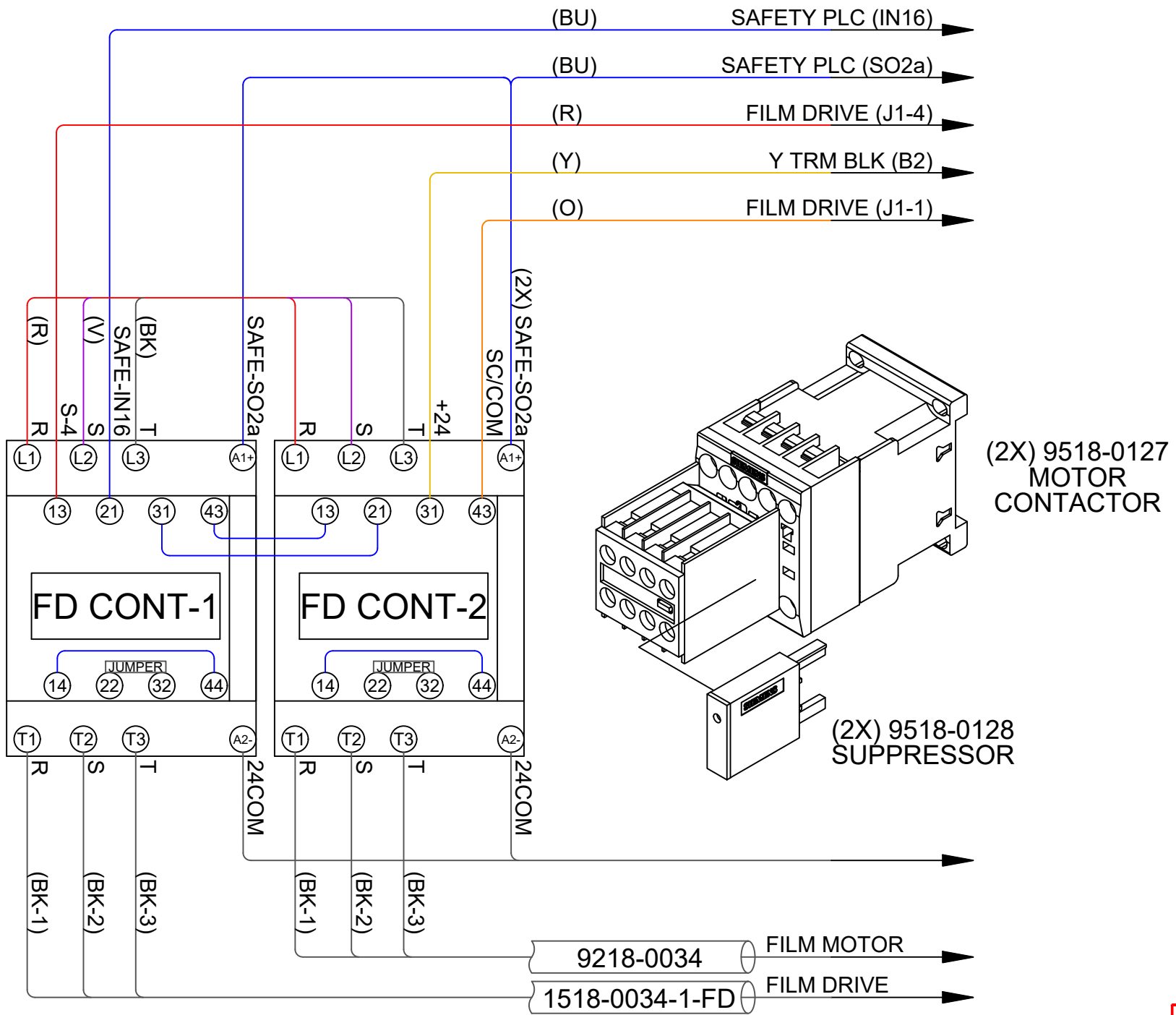
REVISIONS			
NC	INITIAL RELEASE	3.3.21	CH

1500 WIRE DIAGRAMS			
NC	DC SUPPLY (COMPUTER)	3.3.21	CH



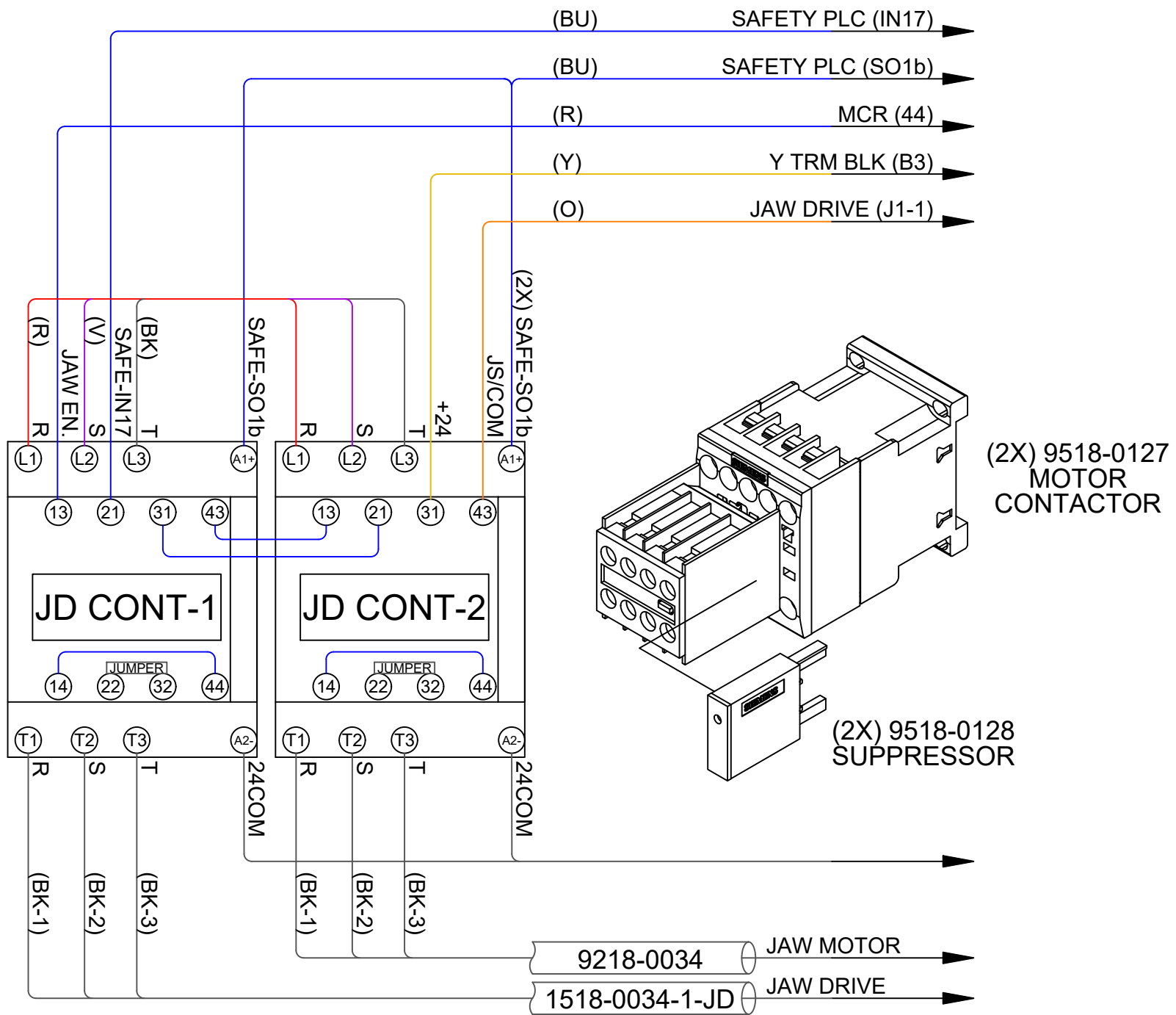
REVISIONS			
NC	INITIAL RELEASE	3.3.21	CH

1500 WIRE DIAGRAMS			
NC	WORK LIGHTS	3.3.21	CH



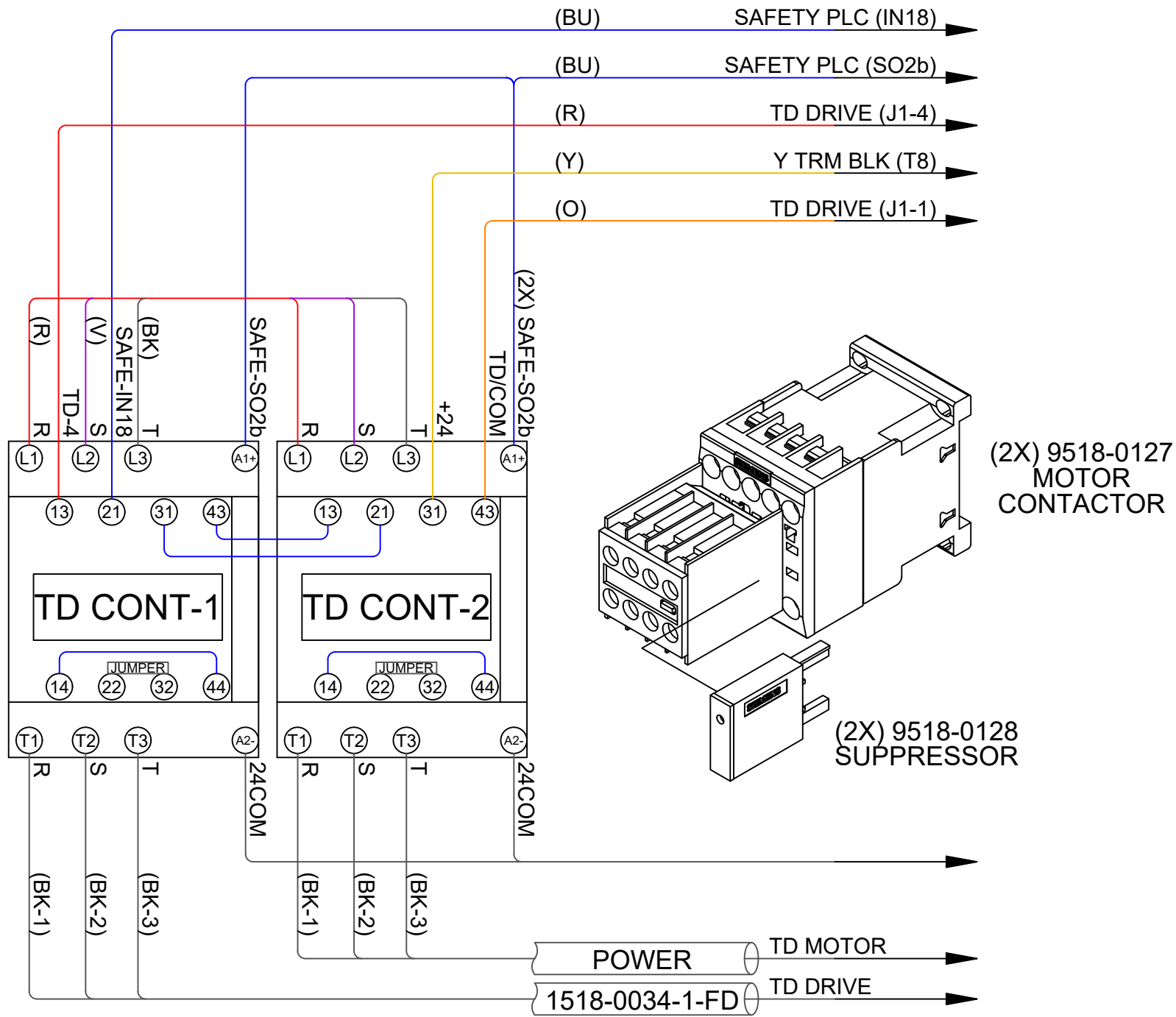
REVISIONS			
NC	INITIAL RELEASE	3.3.21	CH

1500 WIRE DIAGRAMS			
NC	FILM DRIVE CONTACTORS	3.3.21	CH



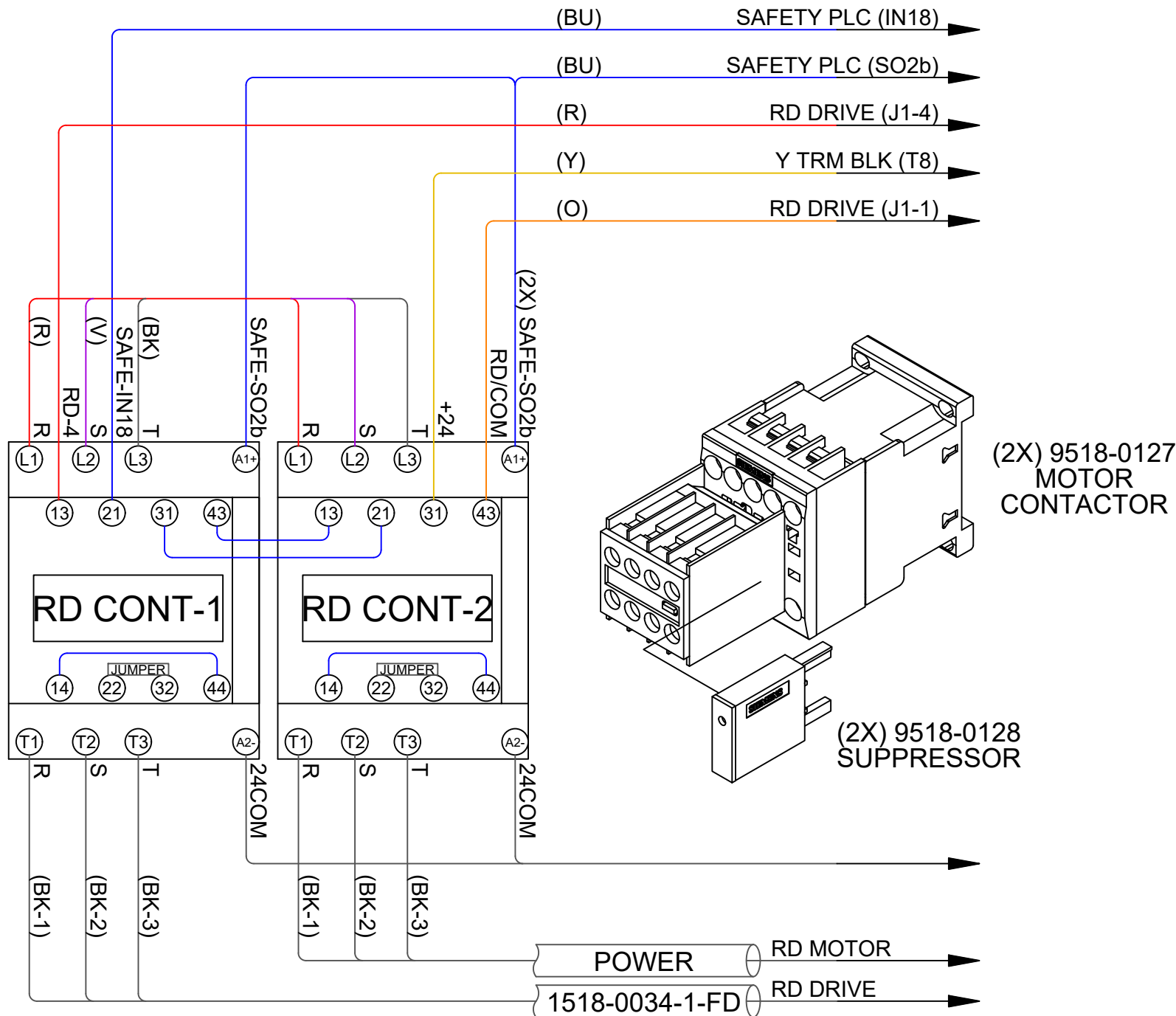
REVISIONS			
NC	INITIAL RELEASE	3.3.21	CH

1500 WIRE DIAGRAMS			
NC	JAW DRIVE CONTACTORS	3.3.21	CH



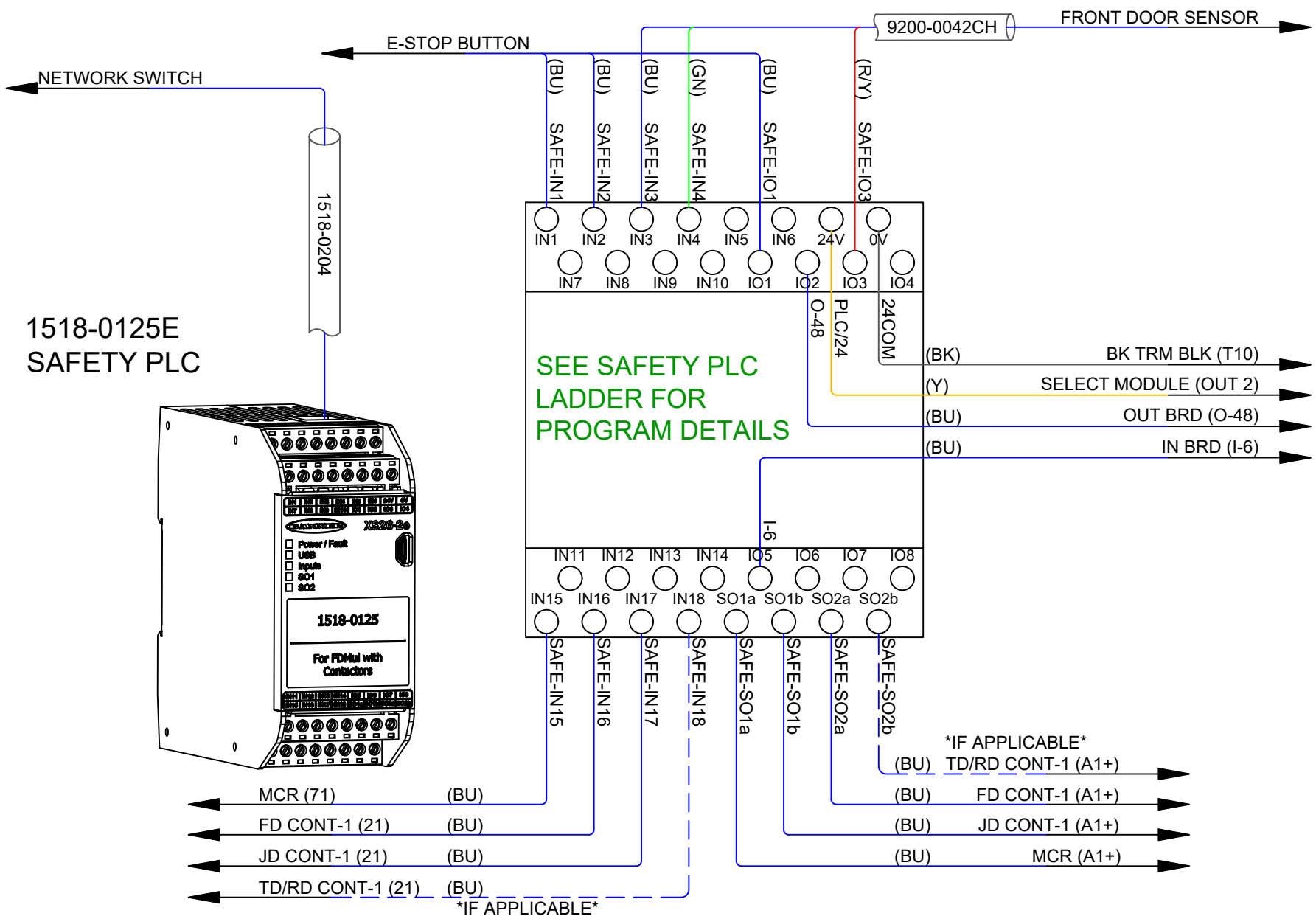
REVISIONS			
NC	INITIAL RELEASE	3.3.21	CH

1500 WIRE DIAGRAMS			
NC	TRANSVERSE DRIVE CONTACTORS	3.3.21	CH



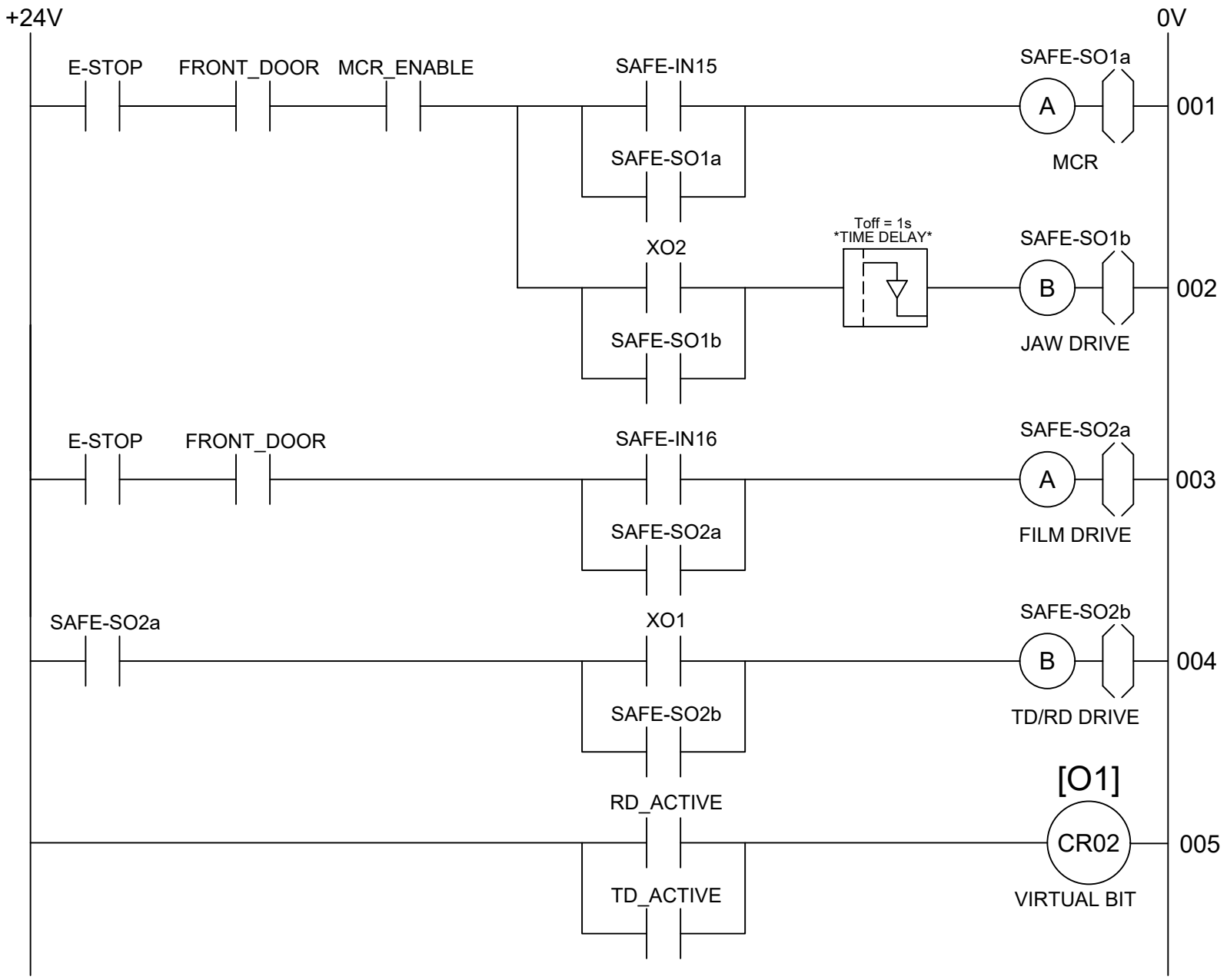
REVISIONS			
NC	INITIAL RELEASE	3.3.21	CH

1500 WIRE DIAGRAMS			
NC	RATIO DRIVE CONTACTORS	3.3.21	CH



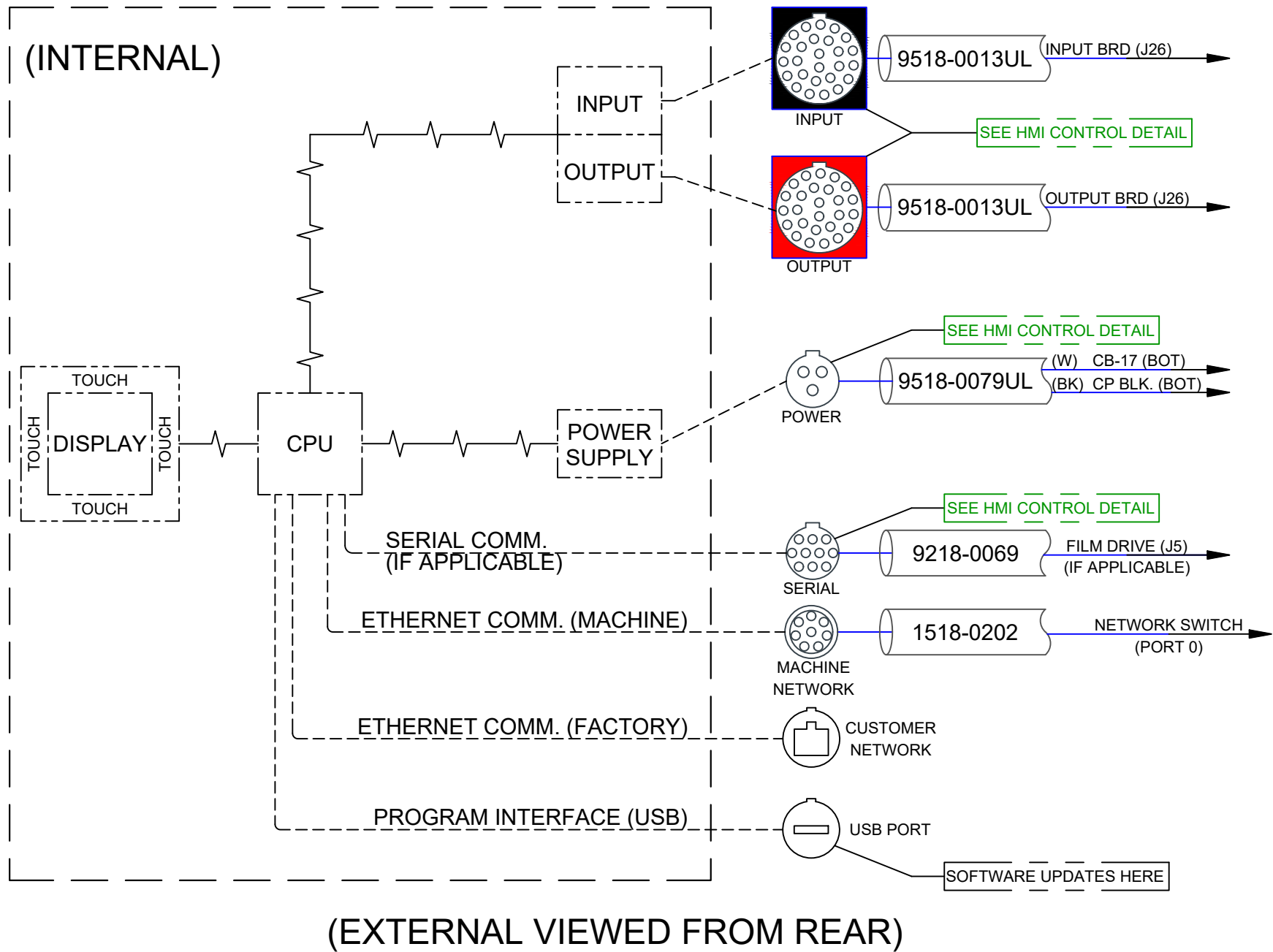
REVISIONS			
NC	INITIAL RELEASE	3.3.21	CH

1500 WIRE DIAGRAMS			
NC	SAFETY PLC	3.3.21	CH



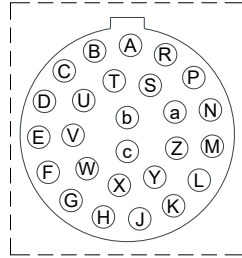
REVISIONS			
NC	INITIAL RELEASE	3.3.21	CH

1500 WIRE DIAGRAMS			
NC	PLC LADDER DIAGRAM	3.3.21	CH



REVISIONS			
NC	INITIAL RELEASE	3.3.21	CH

1500 WIRE DIAGRAMS			
NC	10W300 HMI CONTROL	3.3.21	CH

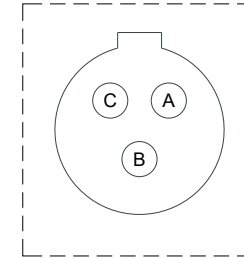


INPUTS

PIN	SIGNAL	DESCRIPTION
C	I-23	SJ IN POSITION
D	I-22	SCALE OVERLOAD
E	I-21	TD DRIVE END
F	I-20	TD FAULT
G	I-19	U/S FAULT
H	I-18	SJ FAULT
J	I-17	PRINTER
K	I-16	TEMP DEVIATION
L	I-15	SCALE READY
M	I-14	JAW CLOSE
P	I-13	JAW OPEN
R	I-12	FILM DRIVE END
A	I-11	REG. MARK NOT DETECT
S	I-10	RESET/START BUTTON
T	I-9	PRODUCT DETECT
U	I-8	FILM OUT
V	I-7	LOW AIR
W	I-6	SERVO FAULT
X	I-5	E-STOP BUTTON
Y	I-4	NIP ROLLER
Z	I-3	REAR DOOR
a	I-2	FRONT DOOR
b	I-1	MCR
c	I-0	24VDC SUPPLY
B	+5	5VDC SUPPLY
N	COM	5VDC COMMON

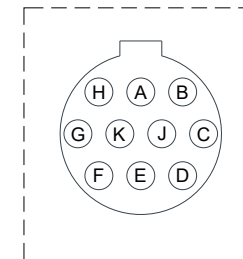
OUTPUTS

PIN	SIGNAL	DESCRIPTION
C	O-23	MCR ENABLE
D	O-22	AUX 5
E	O-21	AUX 4
F	O-20	AUX 3
G	O-19	IN CYCLE
H	O-18	START LAMP
J	O-17	PRINTER
K	O-16	BAGGER PULSE
L	O-15	SELECT LINE 2
M	O-14	SELECT LINE 1
P	O-13	FILM DRIVE
R	O-12	FILM JOG
A	O-11	FILM DRIVE BELTS
S	O-10	AUX 2
T	O-9	STAGER
U	O-8	CUTTER BLADE
V	O-7	HORIZ. SEAL COOLER
W	O-6	HORIZ. SEAL HEATER
X	O-5	JAWS ASSY
Y	O-4	BAG STRETCHER
Z	O-3	ZIPPER WELD
a	O-2	ZIPPER PINCH
b	O-1	VERTICAL SEAL COOLER
c	O-0	VERTICAL SEAL HEATER
B	+5	5VDC SUPPLY
N	COM	5VDC COMMON



POWER IN

PIN	SIGNAL	DESCRIPTION
A	+24	SUPPLY +
B	24COM	SUPPLY -
C	GND	CABLE SHIELD GROUND



OUTPUTS

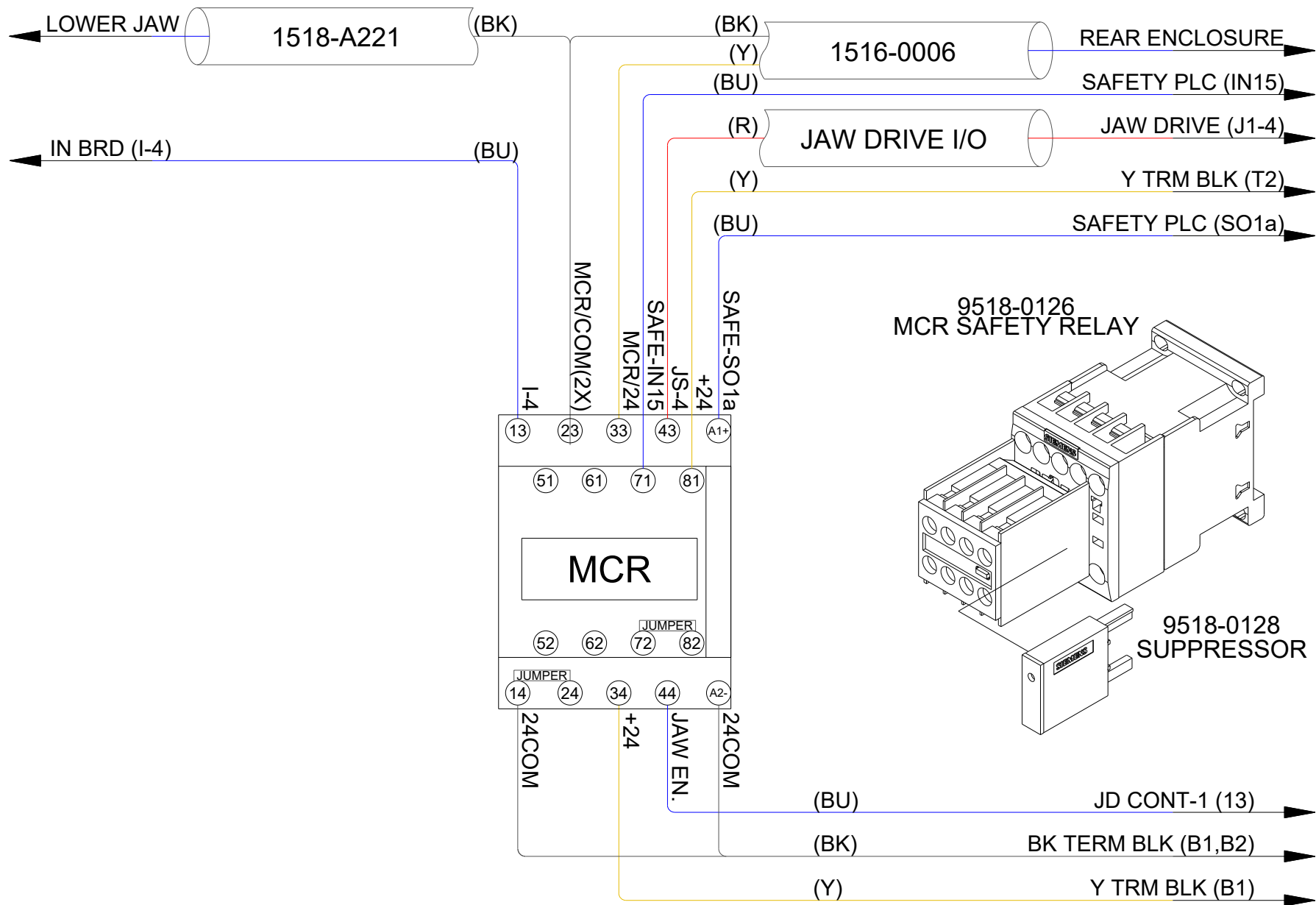
PIN	SIGNAL	DESCRIPTION
A	GND	SERIAL GROUND
B	-	NO CONNECTION
C	-	NO CONNECTION
D	-	NO CONNECTION
E	-	NO CONNECTION
F	-	NO CONNECTION
G	-	NO CONNECTION
H	-	NO CONNECTION
J	TX	RS-232 TX/RX
K	RX	RS-232 RX/TX

REVISIONS

NC	INITIAL RELEASE	3.3.21	CH

1500 WIRE DIAGRAMS

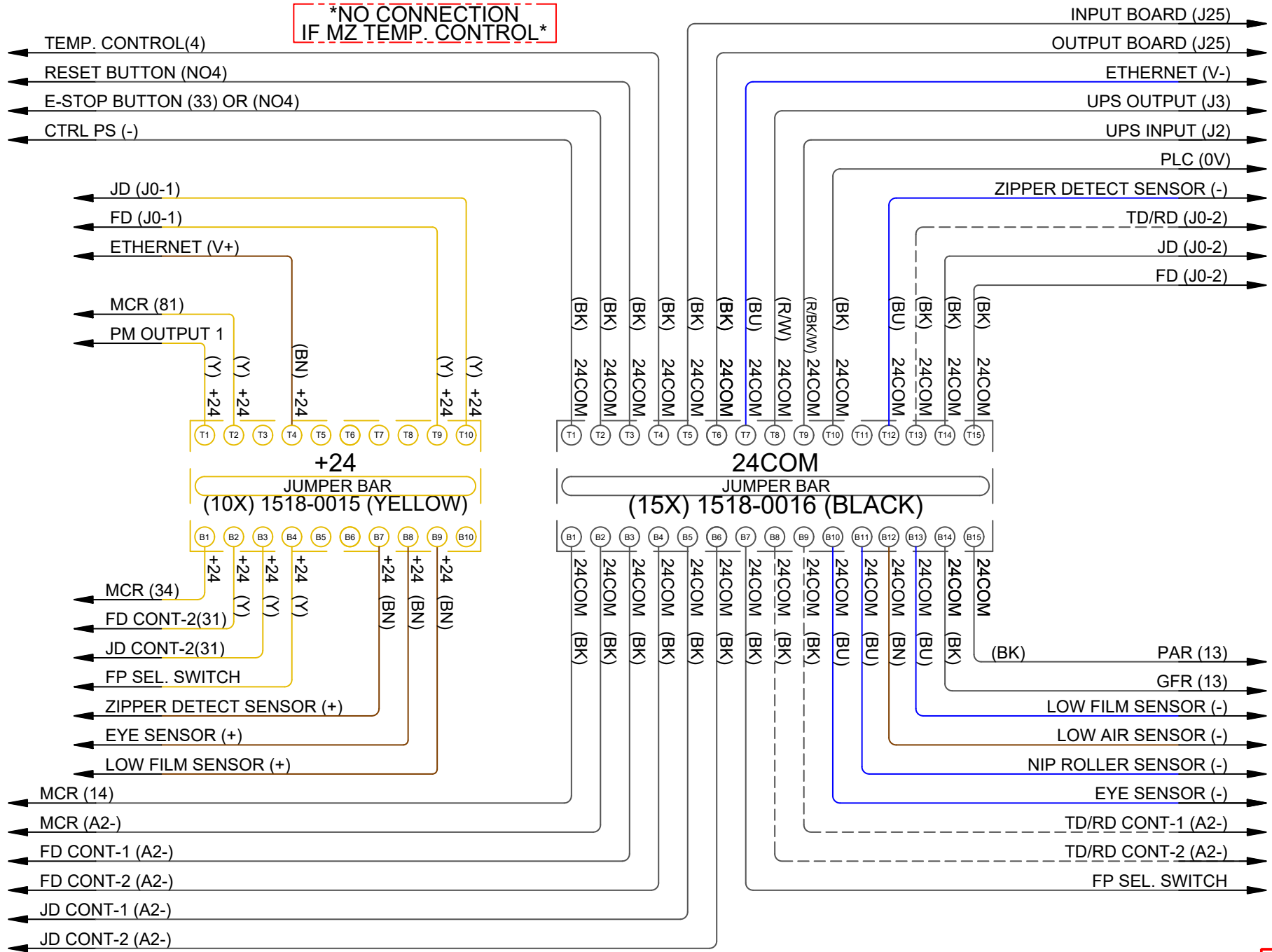
NC	HMI CONTROL DETAIL	3.3.21	CH



REVISIONS			
NC	INITIAL RELEASE	3.3.21	CH

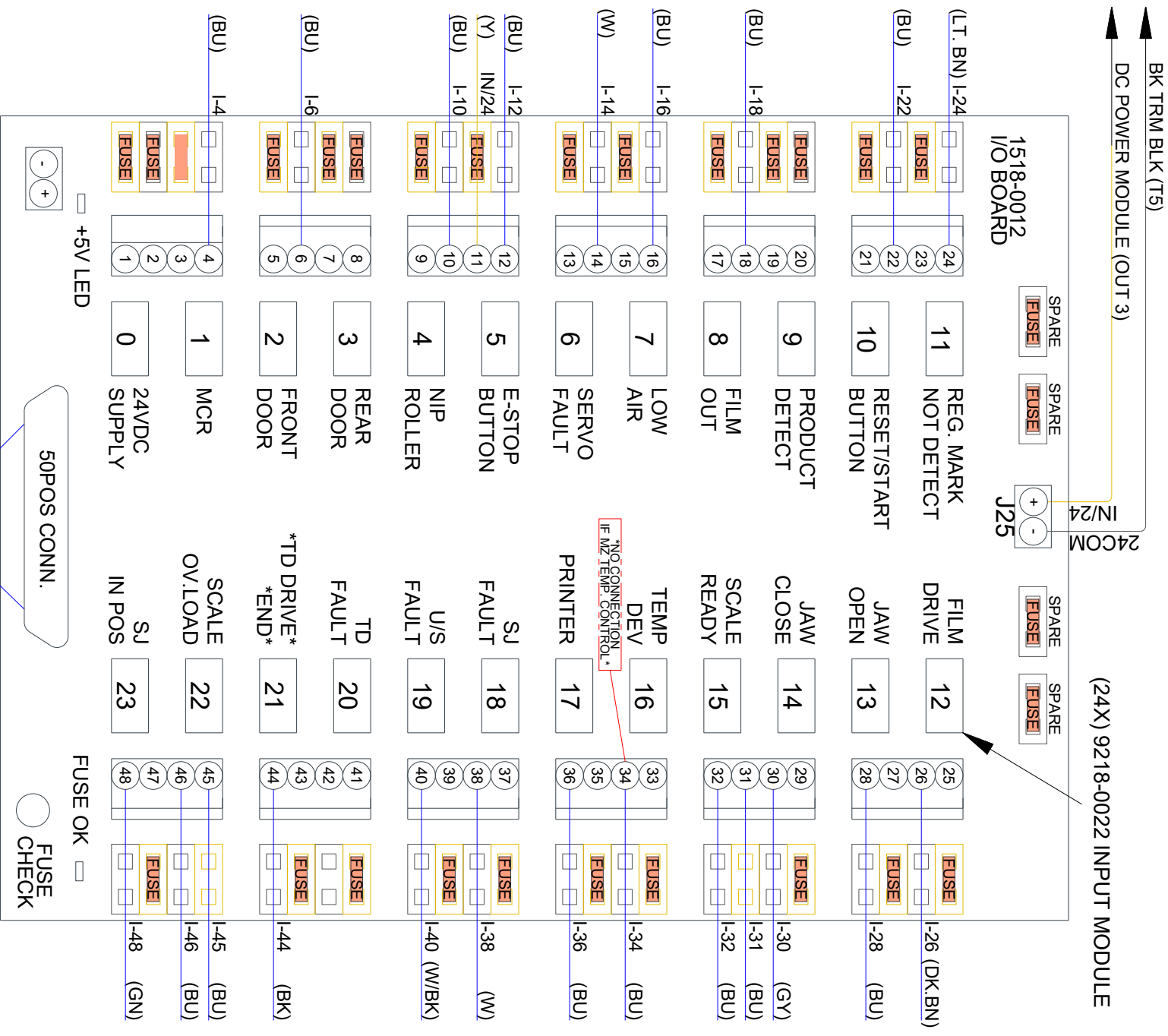
1500 WIRE DIAGRAMS			
NC	MCR RELAY	3.3.21	CH

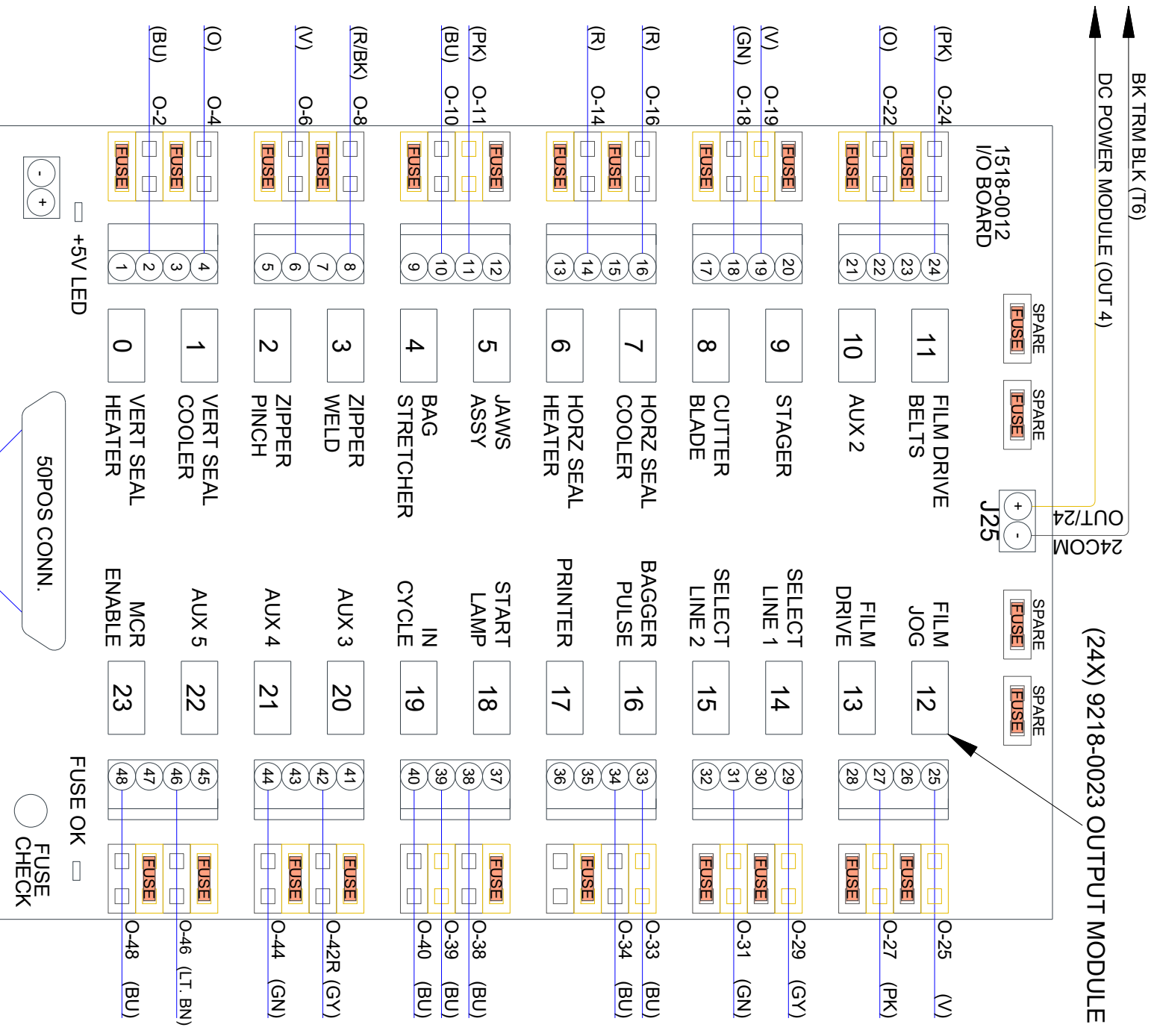
***NO CONNECTION
IF MZ TEMP. CONTROL***

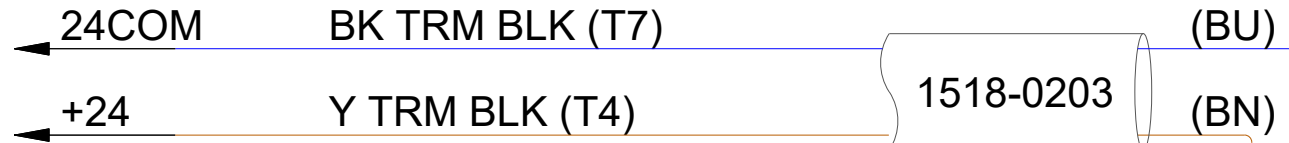


REVISIONS			
NC	INITIAL RELEASE	3.3.21	CH

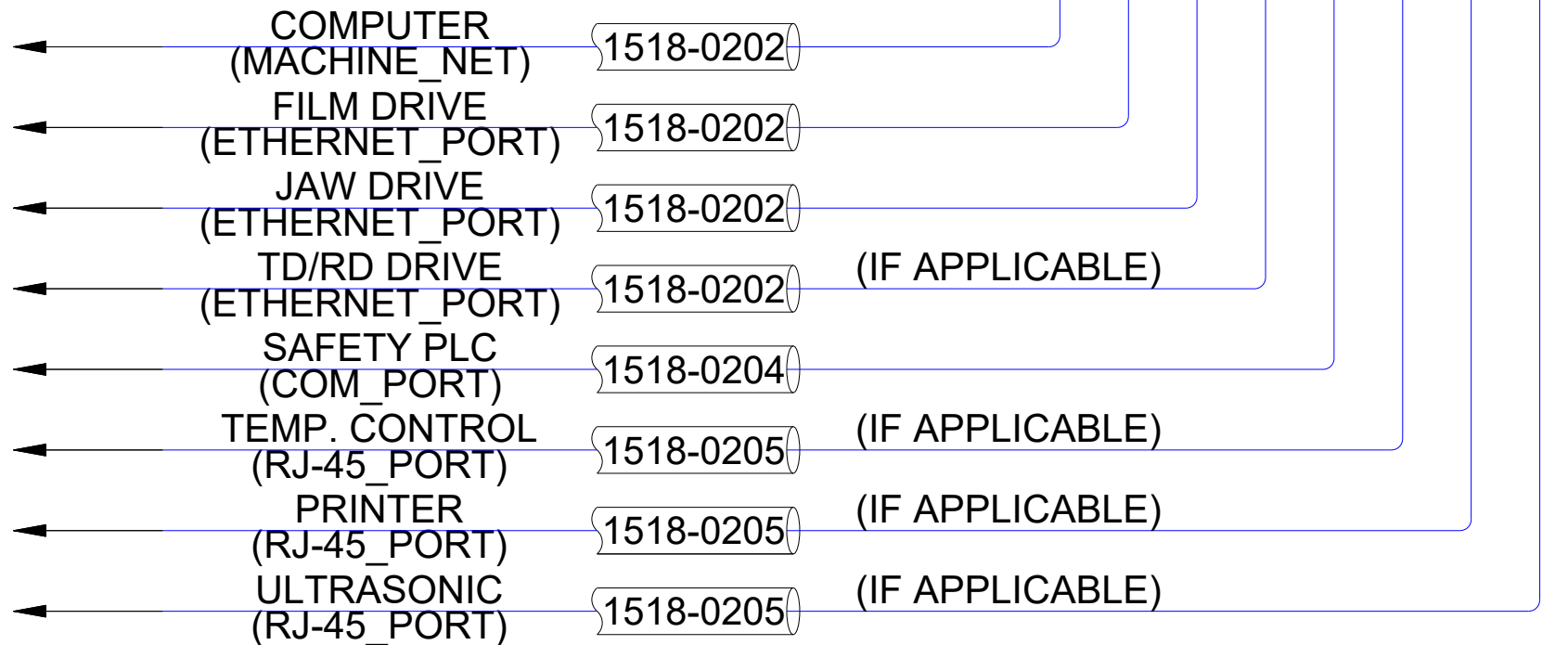
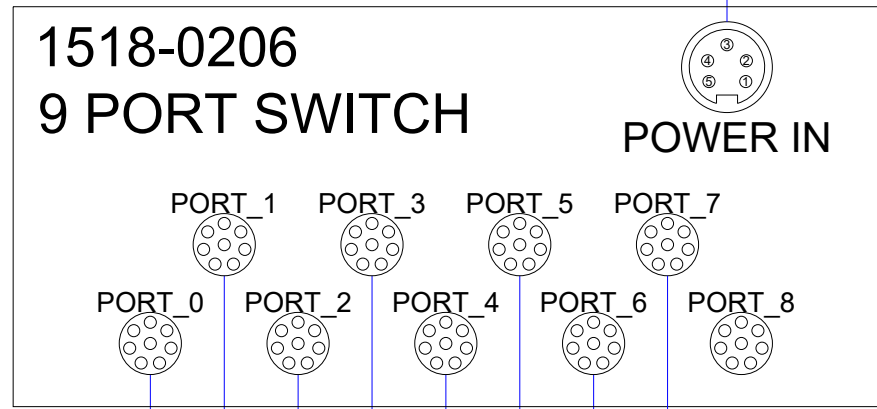
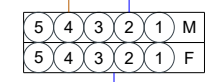
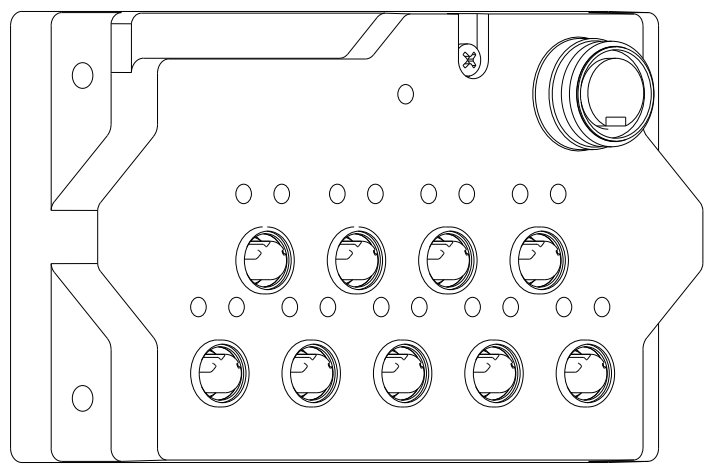
1500 WIRE DIAGRAMS			
NC	CONTROL TERMINAL BLOCKS	3.3.21	CH





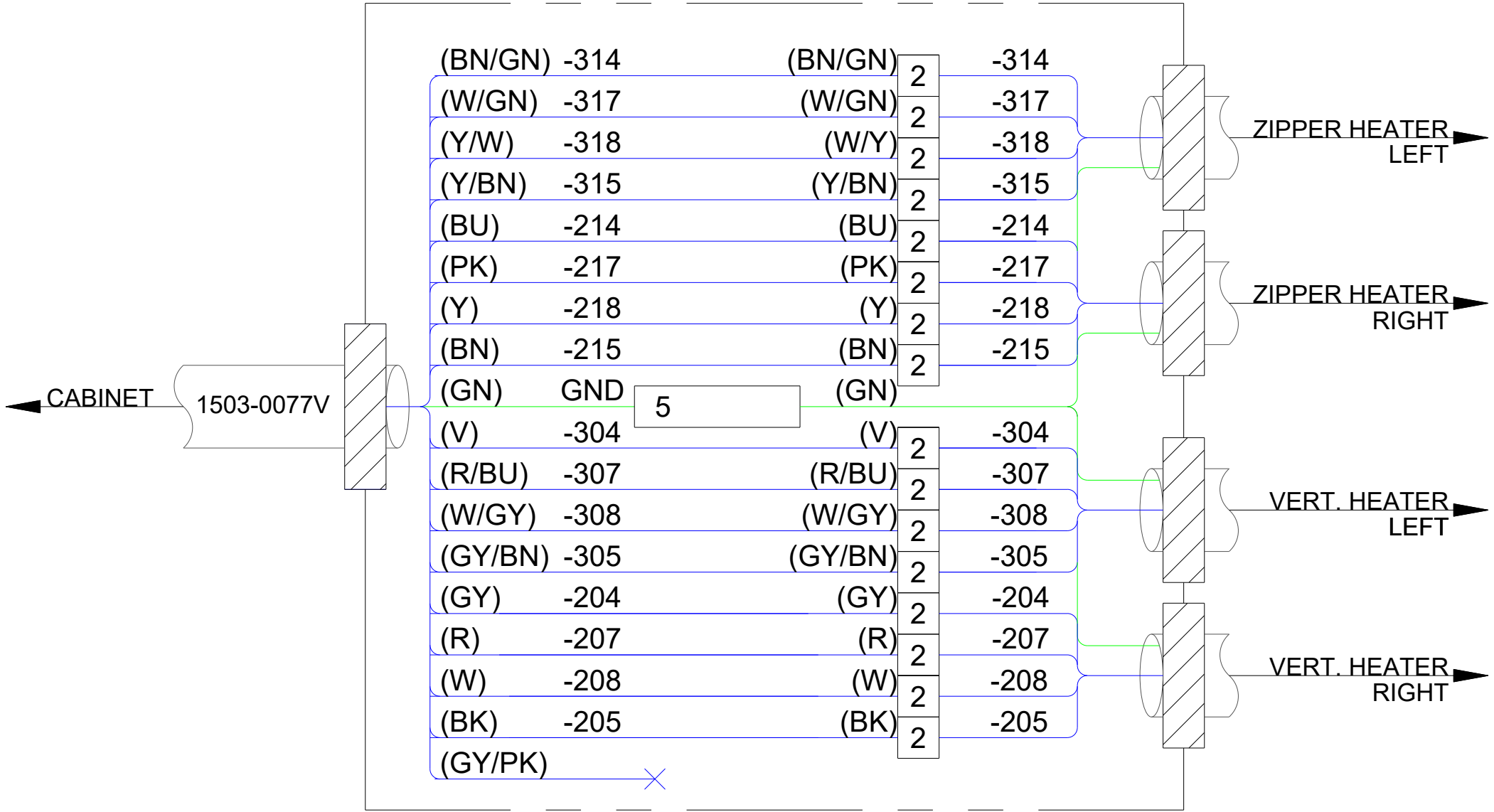


PORT NUMBERS ARE DEVICE SPECIFIC A



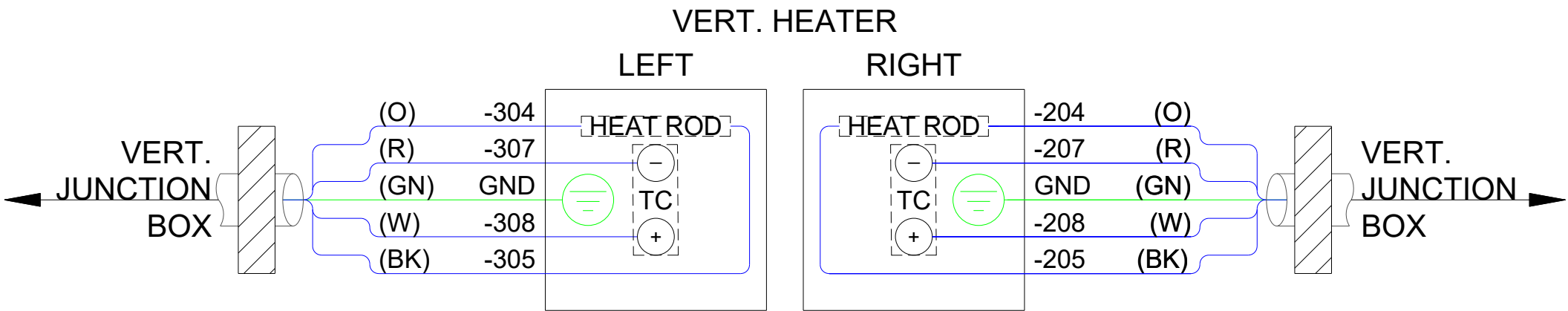
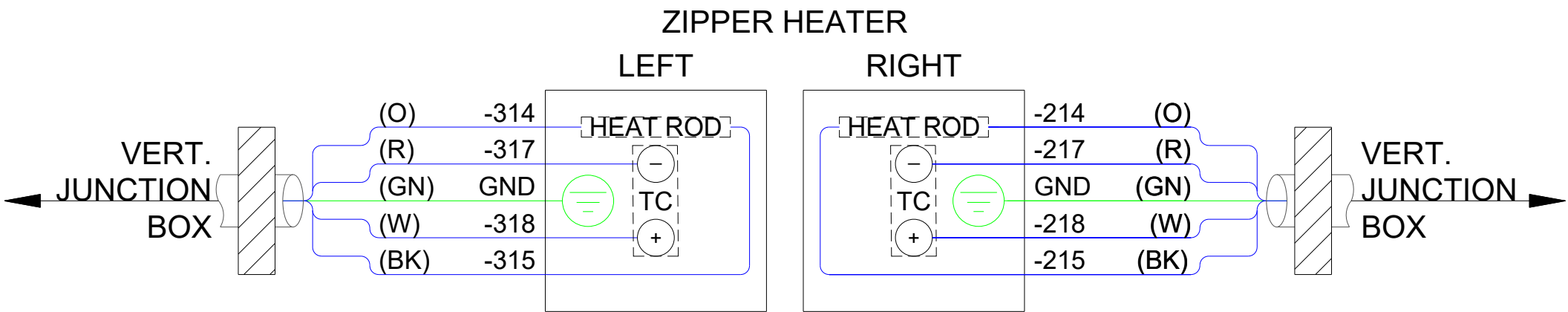
REVISIONS			
A	PORT NUMBERS ARE DEVICE SPECIFIC	5.5.21	CH

1500 WIRE DIAGRAMS			
A	NETWORK SWITCH	5.5.21	CH



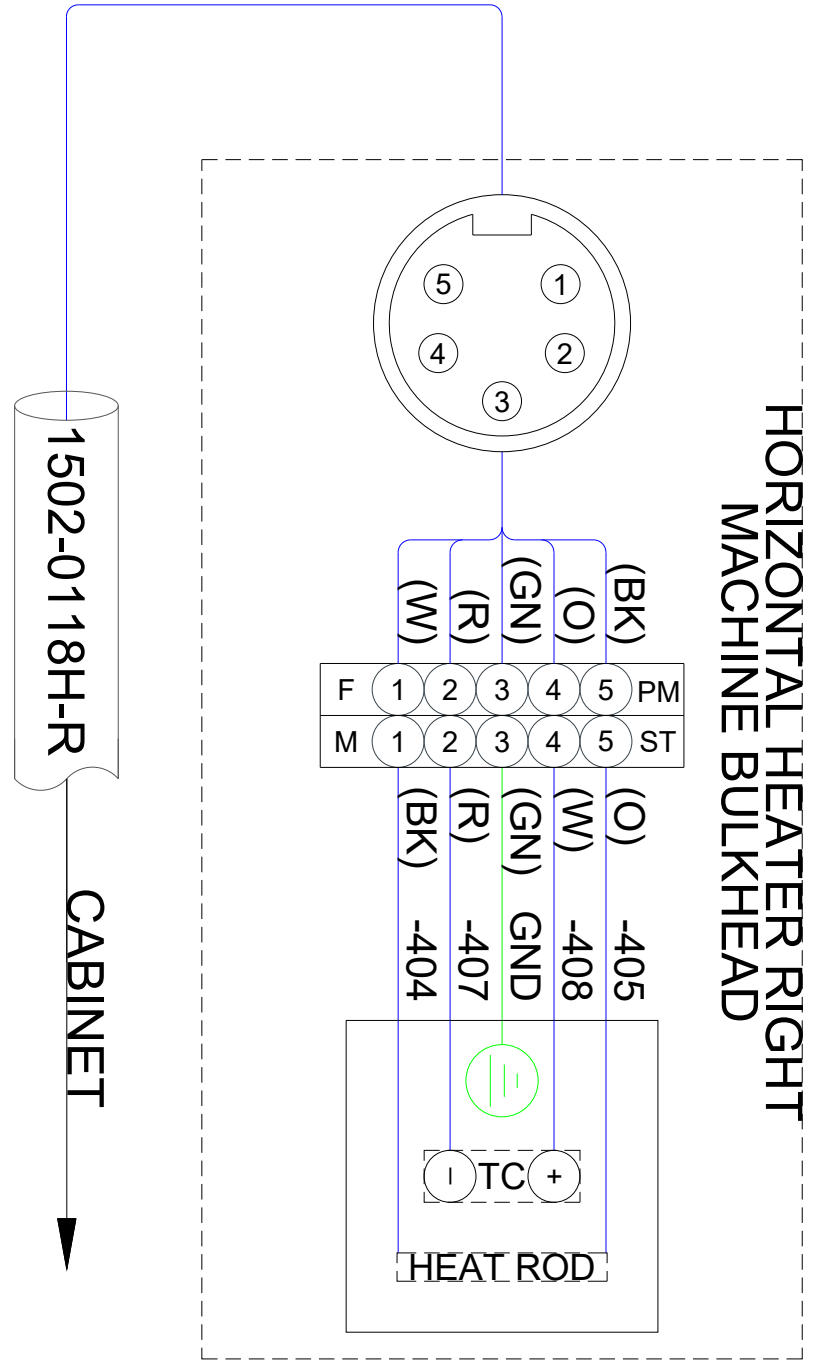
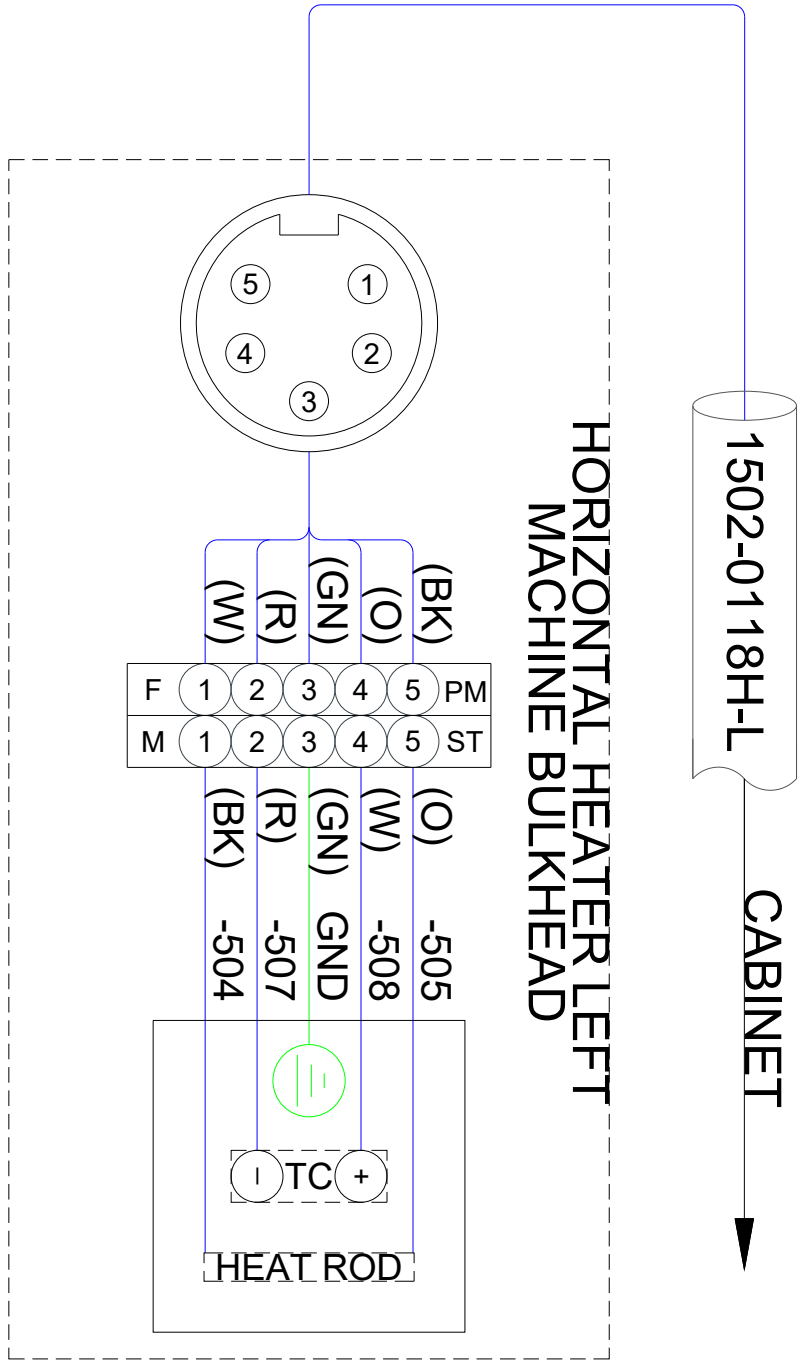
REVISIONS			
NC	INITIAL RELEASE	3.3.21	CH

1500 WIRE DIAGRAMS			
NC	VERTICAL SEAL JUNCTION BOX	3.3.21	CH



REVISIONS			
NC	INITIAL RELEASE	3.3.21	CH

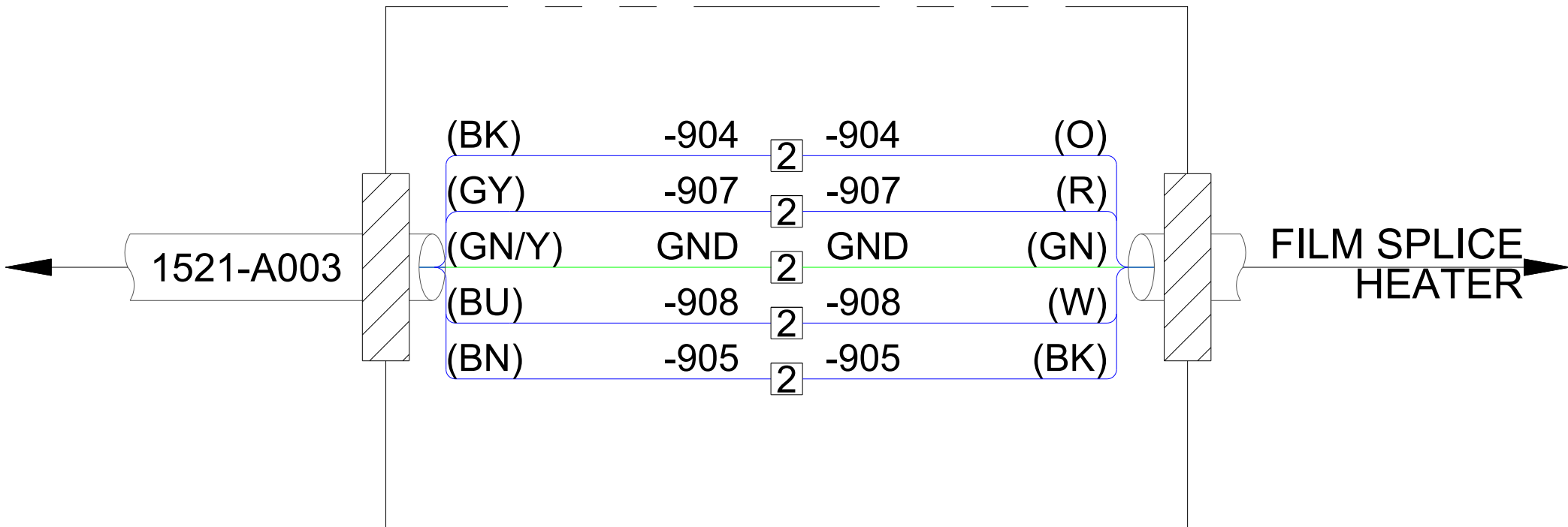
1500 WIRE DIAGRAMS			
NC	VERT./ZIPPER HEATER ASSY	3.3.21	CH

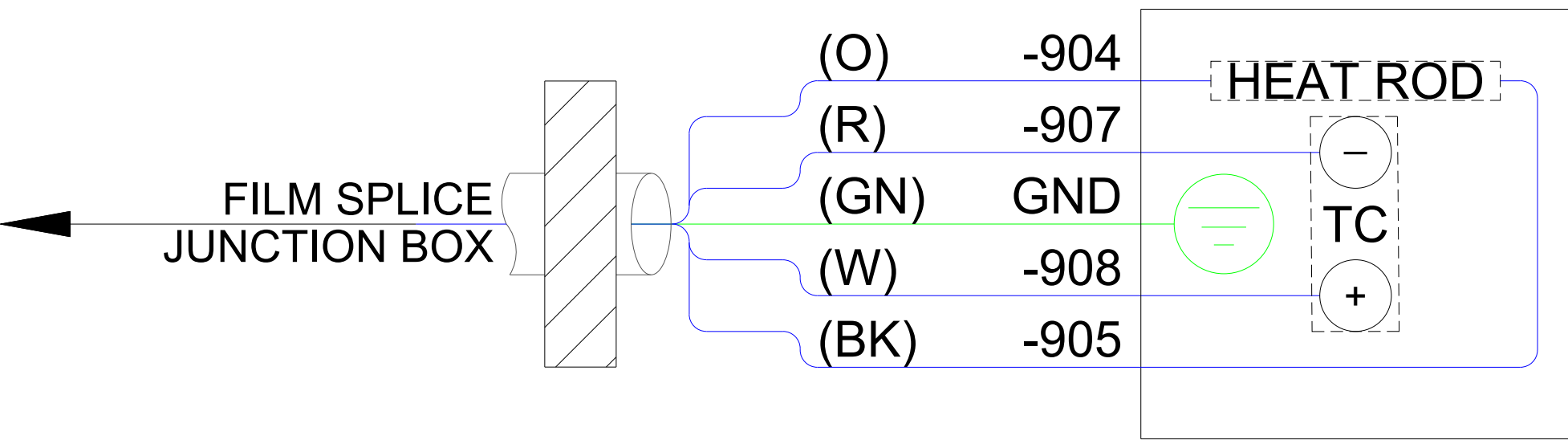


REVISIONS			
NC	INITIAL RELEASE	3.3.21	CH

1500 WIRE DIAGRAMS			
NC	HORIZONTAL HEATER ASSY	3.3.21	CH

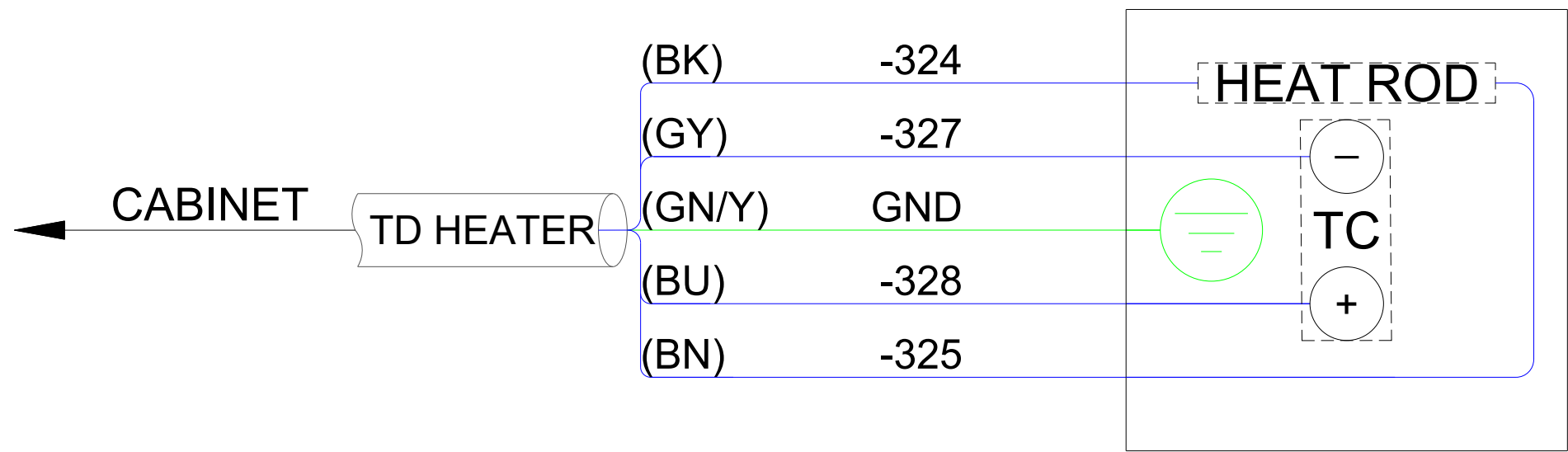
1521-0128 A2 JUNCTION BOX





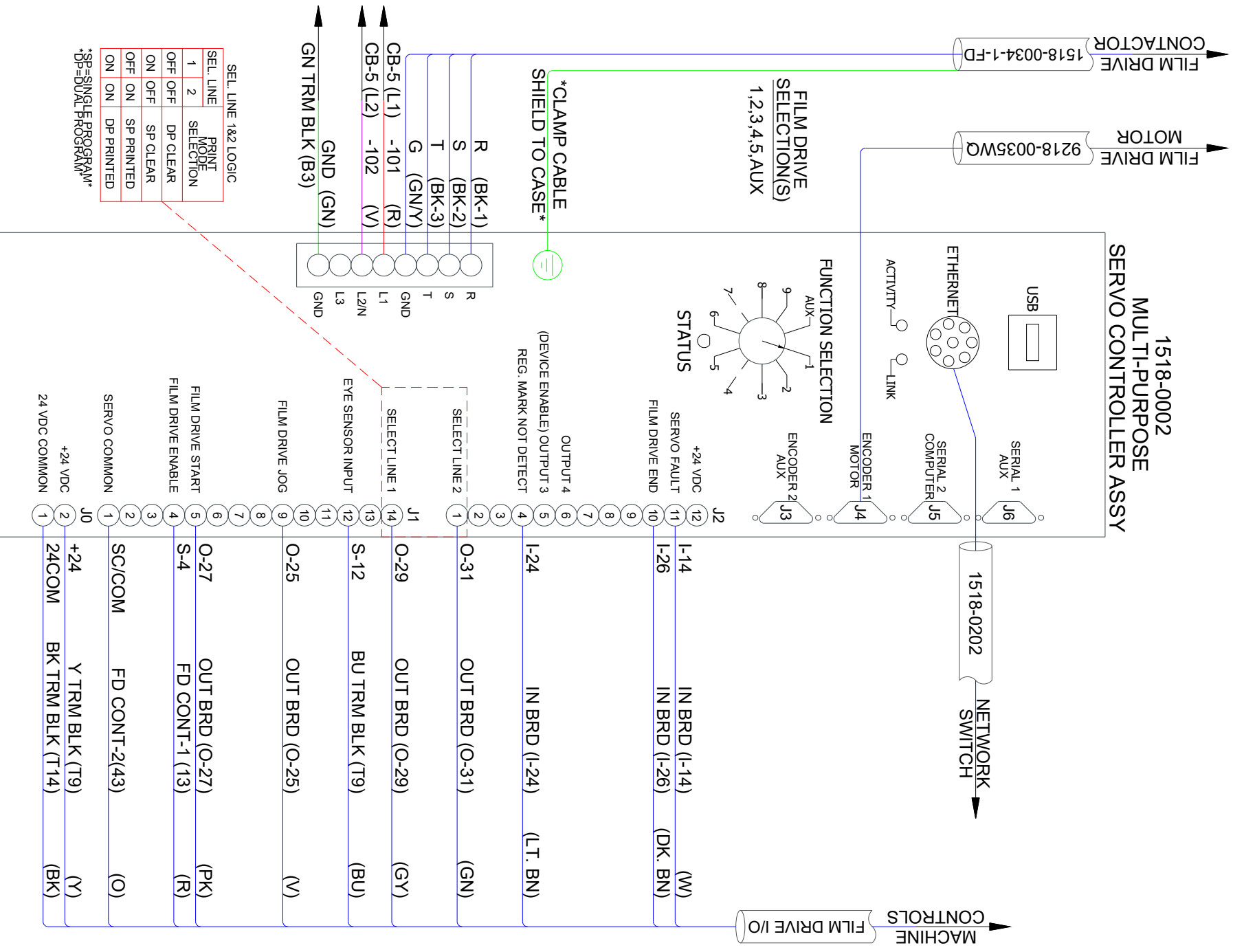
REVISIONS			
NC	INITIAL RELEASE	3.3.21	CH

		PG. 040	
1500 WIRE DIAGRAMS			
NC	FILM SPLICE HEATER	3.3.21	CH



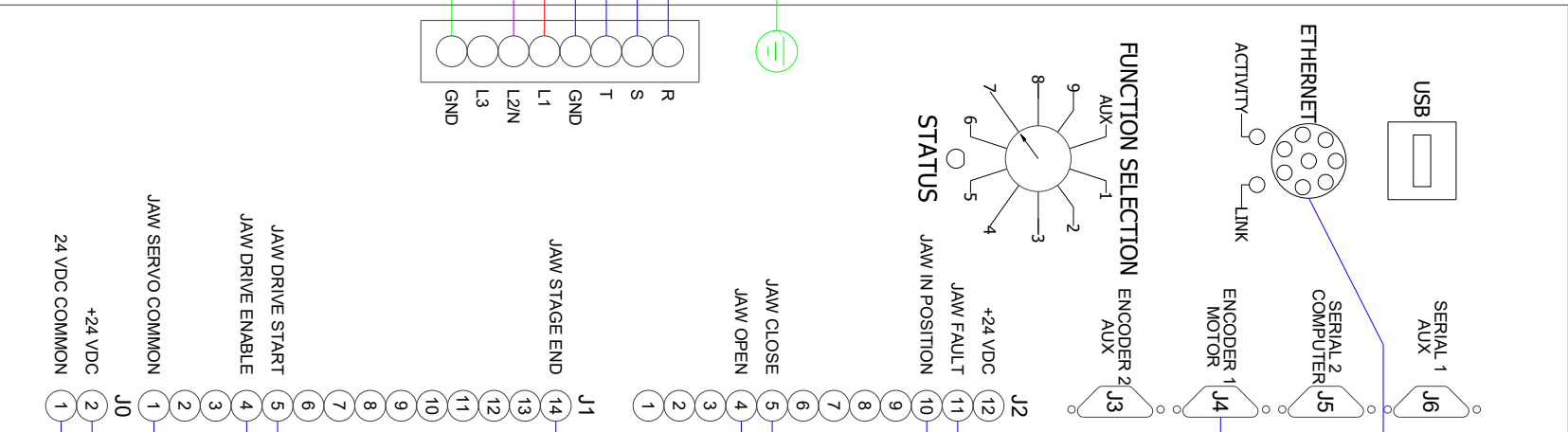
REVISIONS			
NC	INITIAL RELEASE	3.3.21	CH

1500 WIRE DIAGRAMS			
NC	TD HEATER ASSY	3.3.21	CH



JAW DRIVE
CONTRACTOR
1518-0034-1-JD

1518-0002
MULTI-PURPOSE
SERVO CONTROLLER ASSY



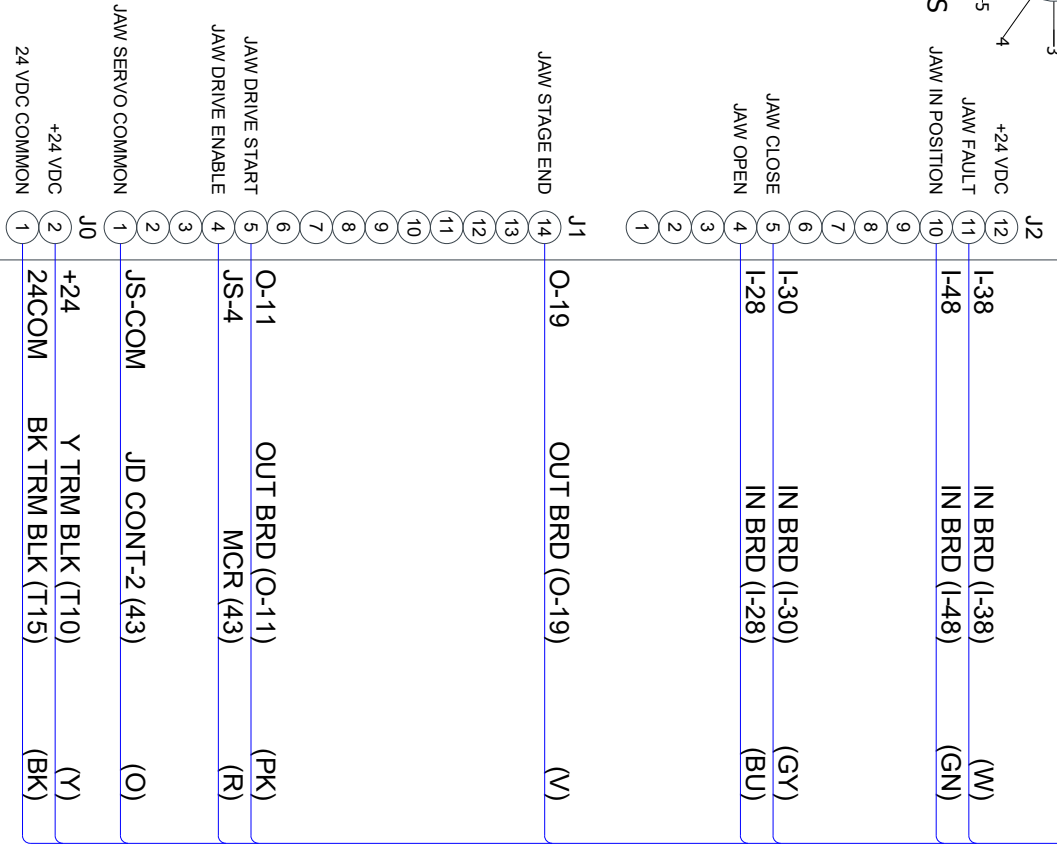
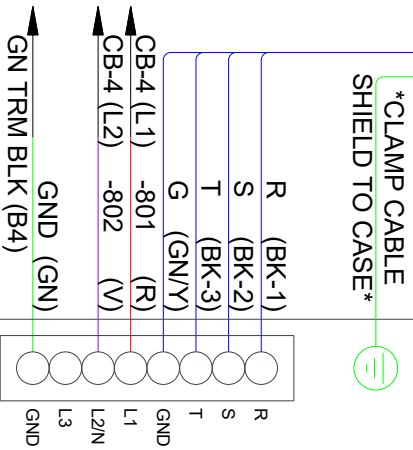
ENCODER

MOTOR TYPE	ENCODER
9201-0001H	9218-0035WQ
9502-0215EX	ATTACHED

1518-0202 NETWORK SWITCH

JAW DRIVE MOTOR

MACHINE CONTROLS
JAW DRIVE I/O

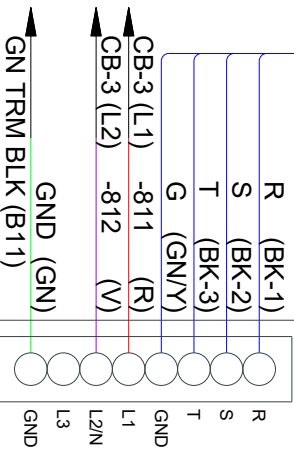


TRANS. DRIVE
CONTRACTOR

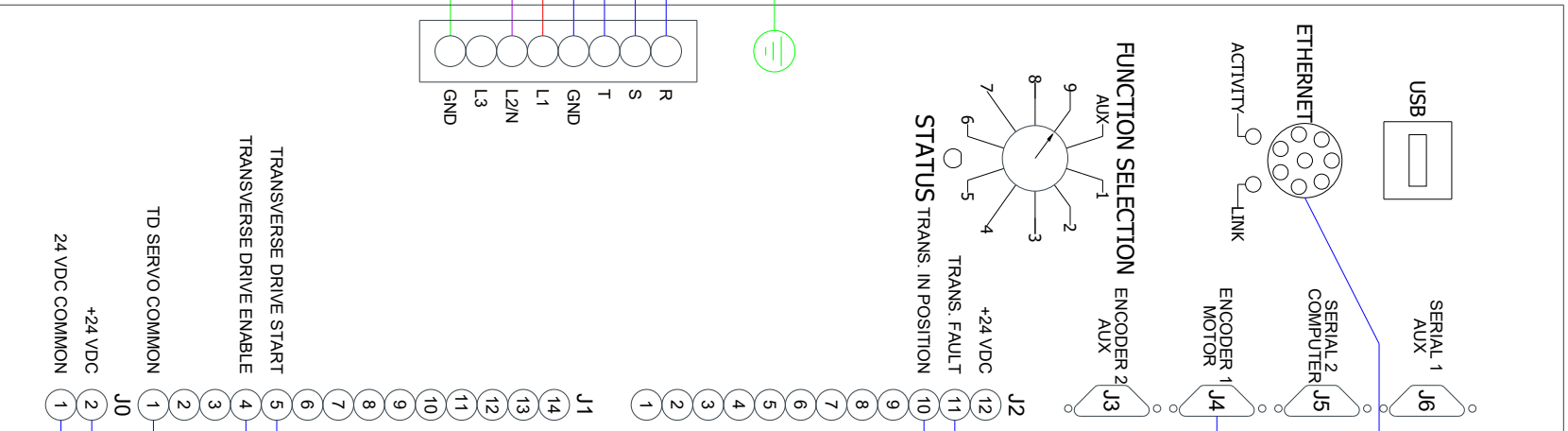
9218-0034-1

TRANS. DRIVE
SELECTION(S)
9.AUX

*CLAMP CABLE
SHIELD TO CASE*



1518-0002
MULTI-PURPOSE
SERVO CONTROLLER ASSY



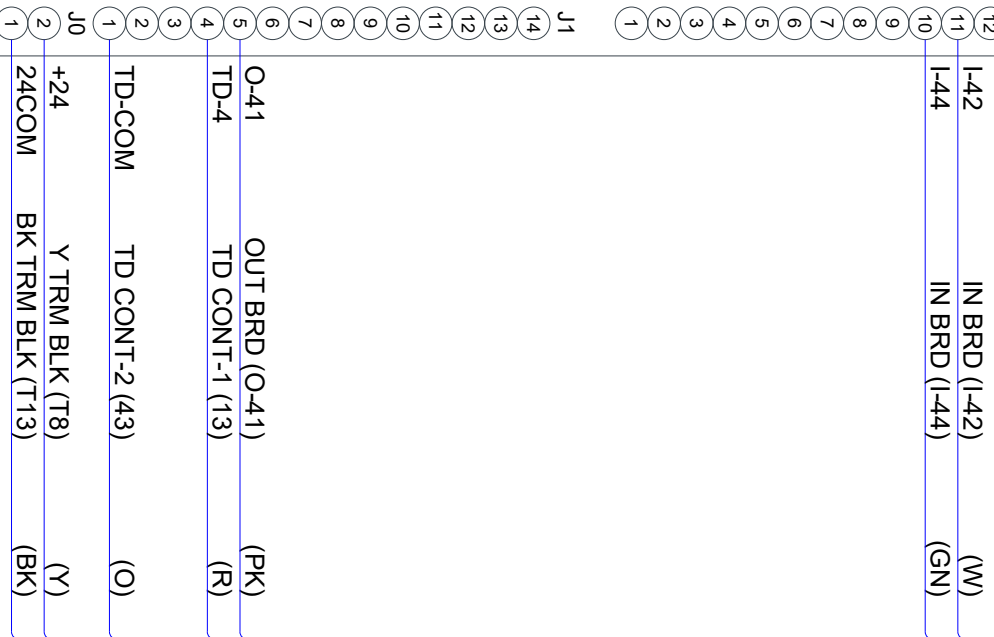
1518-0202 NETWORK SWITCH

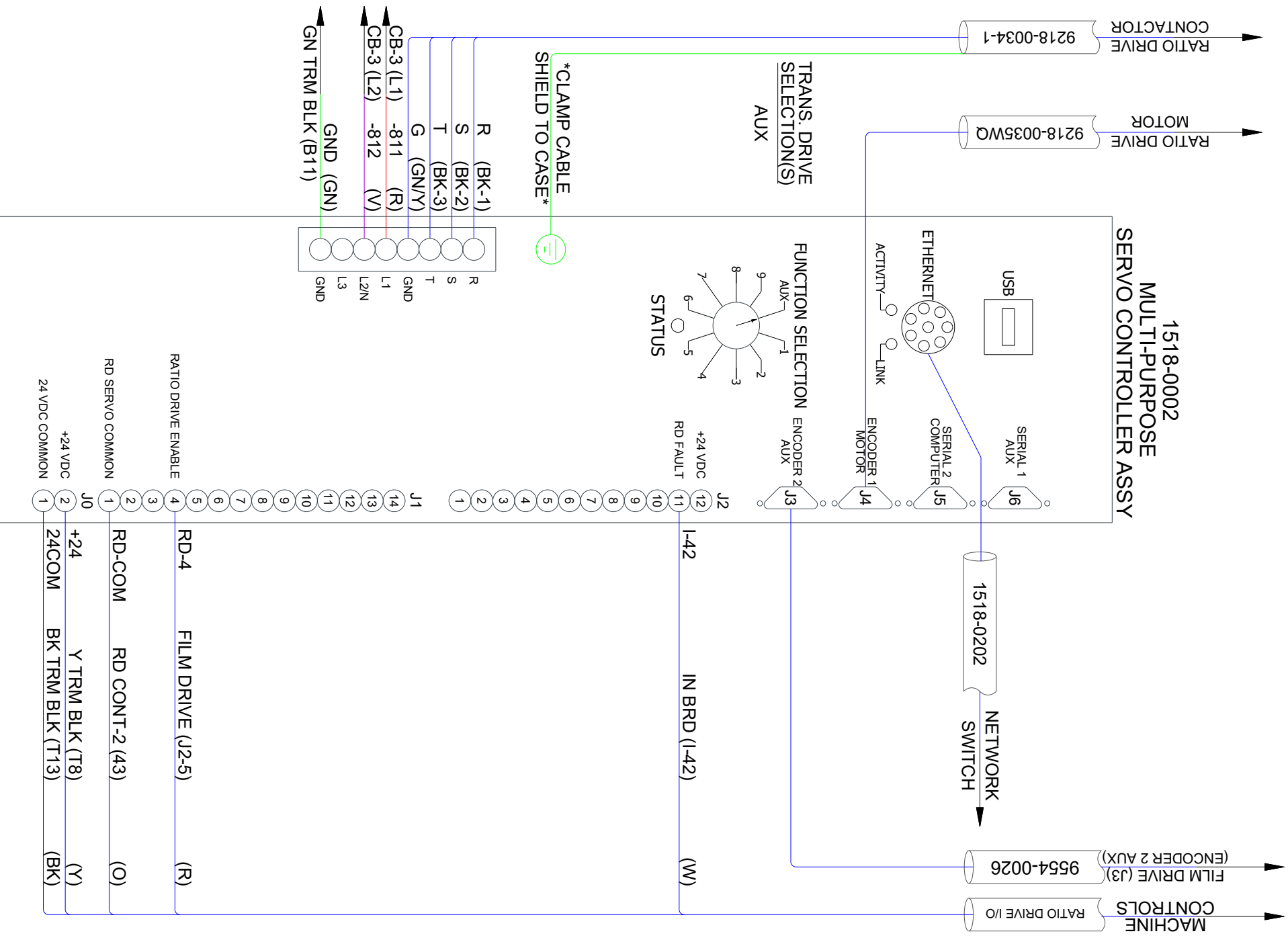
MACHINE
TRANS DRIVE I/O
ENCODER
TRANS. DRIVE MOTOR

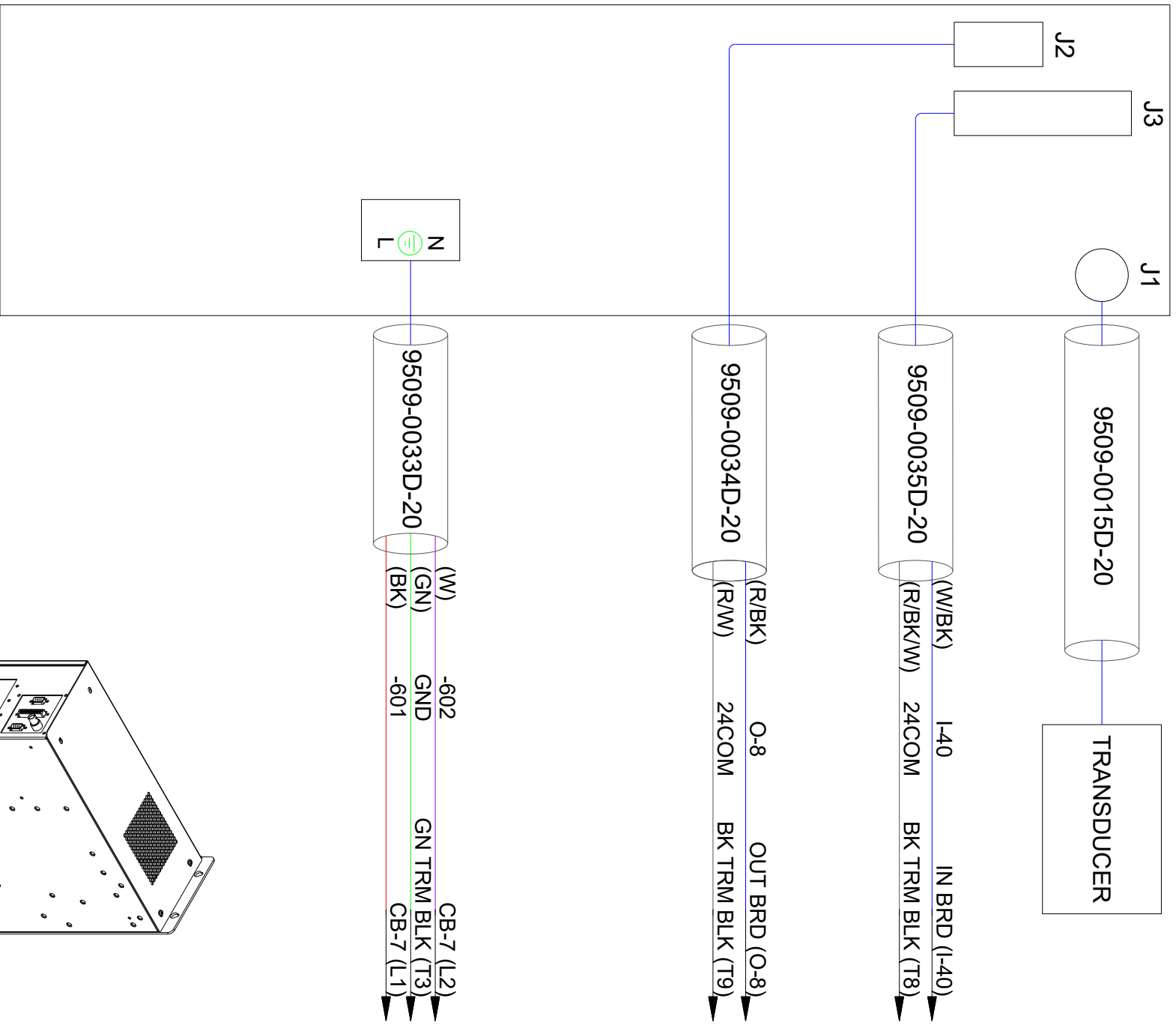
ENCODER

MOTOR TYPE	ENCODER
9568-0004	9568-0002WQ
9502-0215EX	ATTACHED

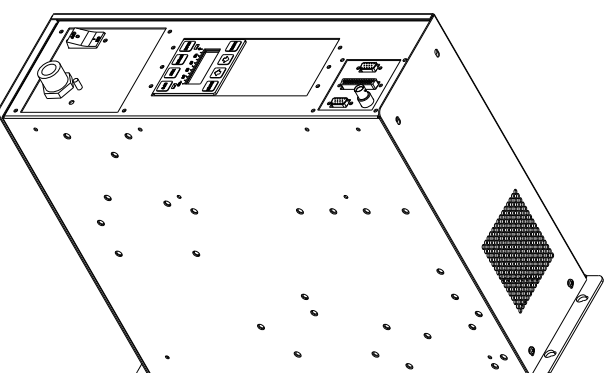
TRANSVERSE DRIVE START
TRANSVERSE DRIVE ENABLE
TD SERVO COMMON
+24 VDC
24 VDC COMMON



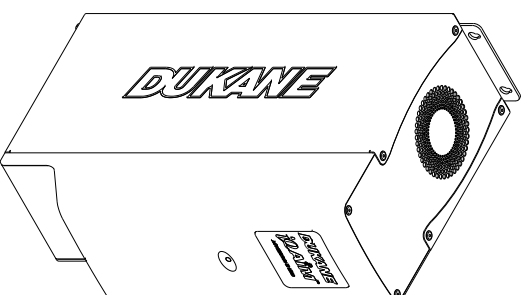




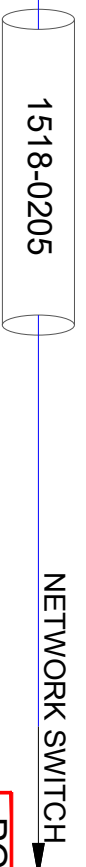
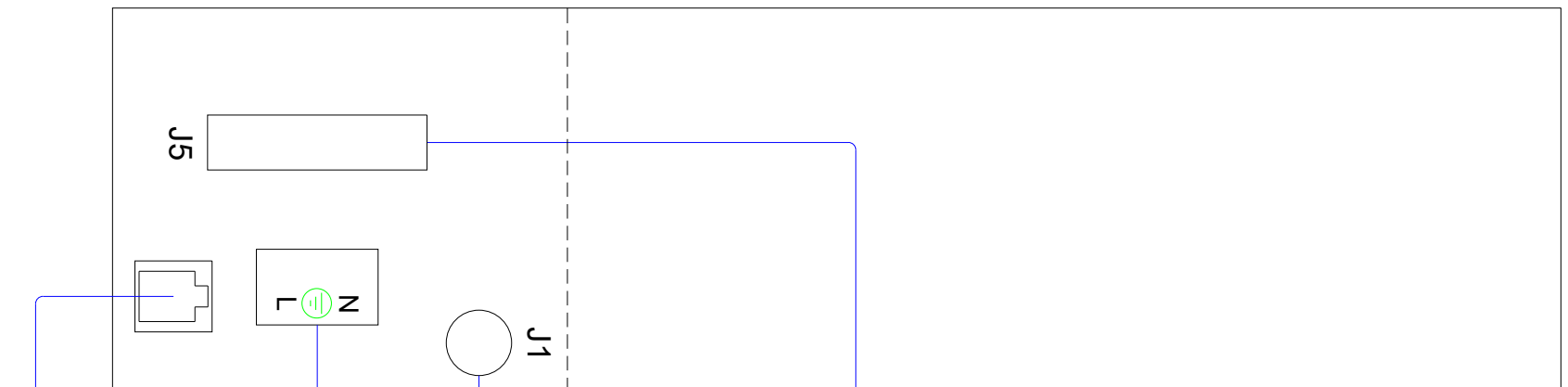
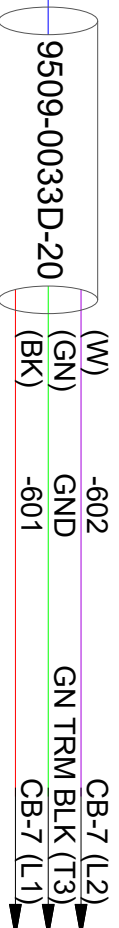
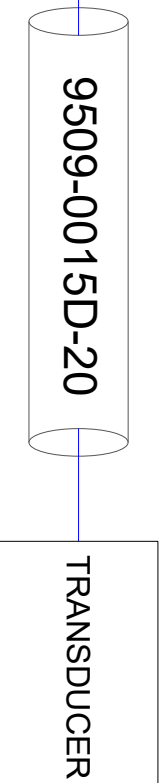
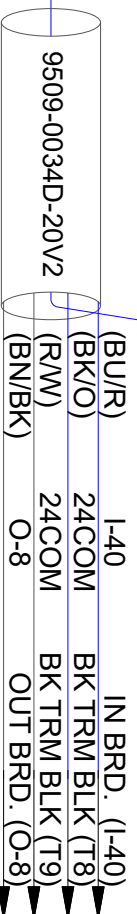
9518-0001D-20
 20KHZ 2400 WATT
 ULTRASONIC PS

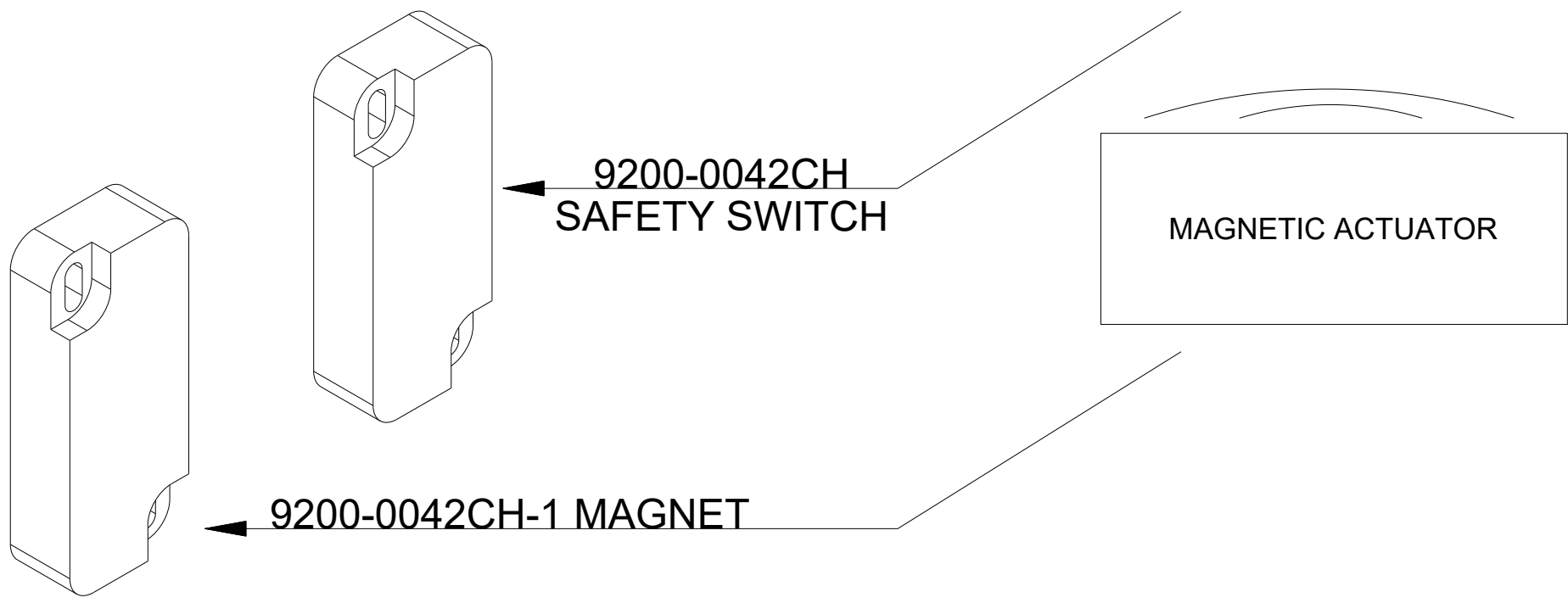
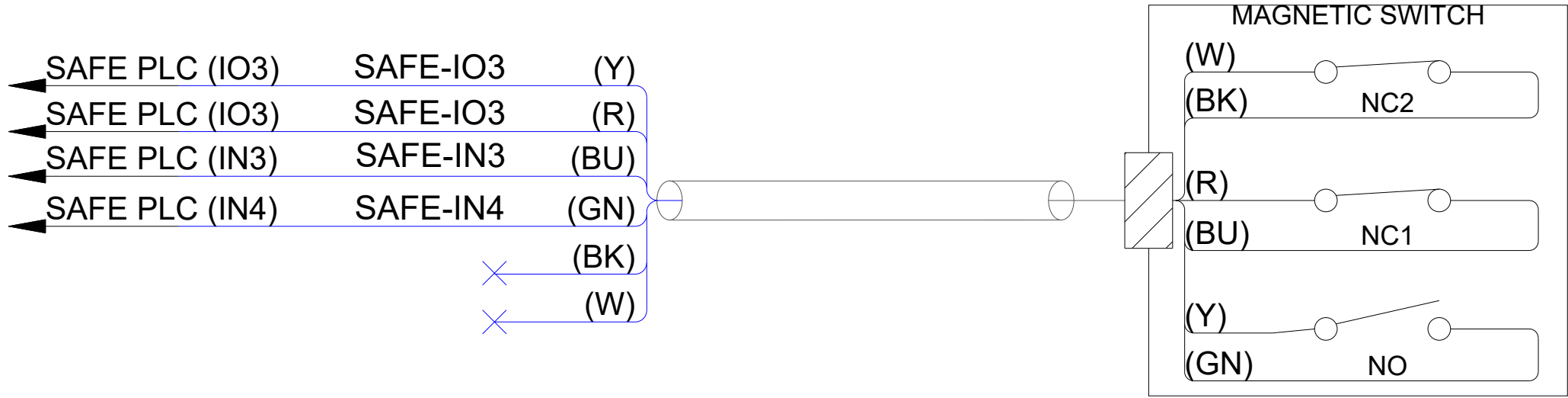


9518-0001D-20V2
20KHZ 2600 WATT
ULTRASONIC PS



(BK/W)
(W/BK)
SOLDER WIRES
TOGETHER
COVER W/ BKHS

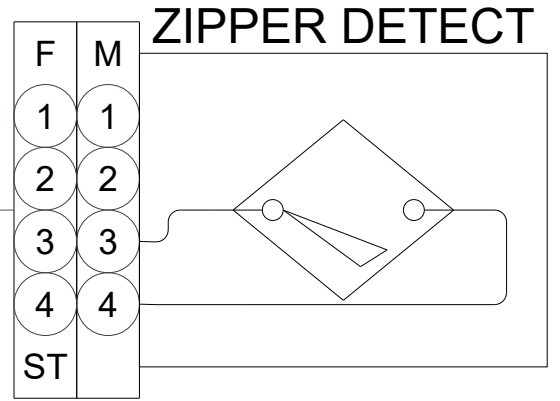
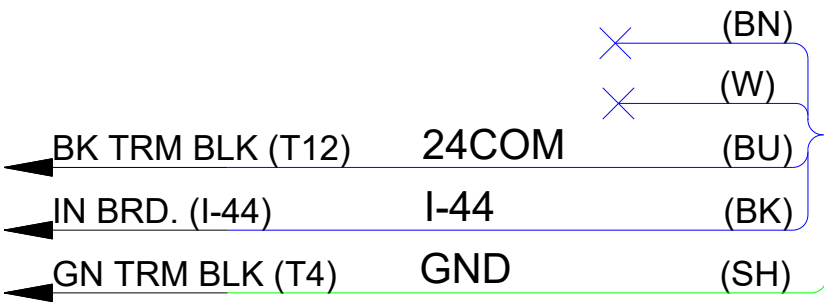
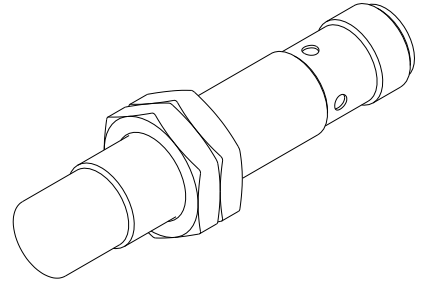
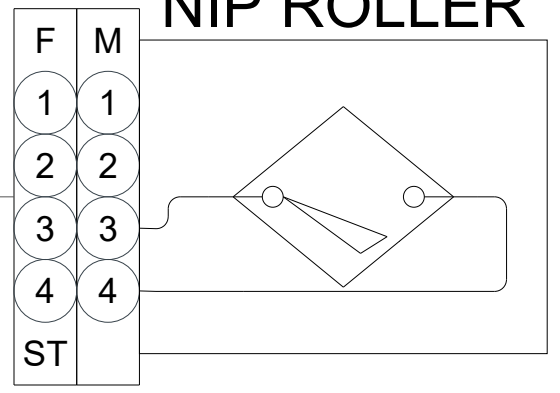
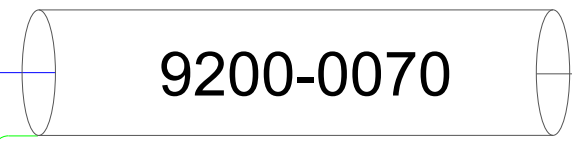
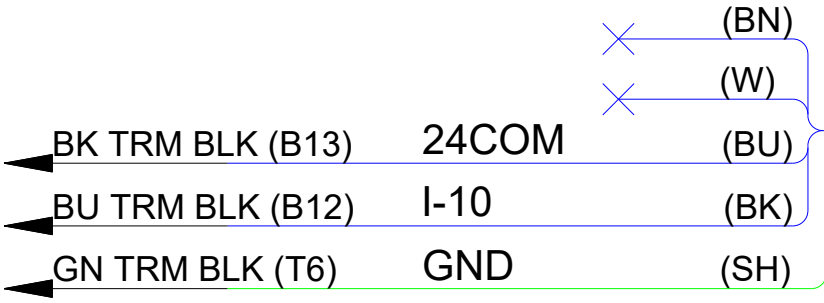


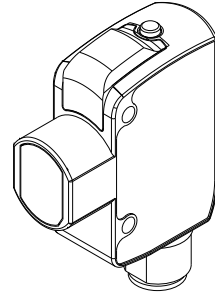


REVISIONS			
NC	INITIAL RELEASE	3.3.21	CH

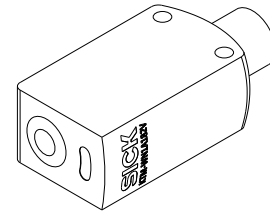
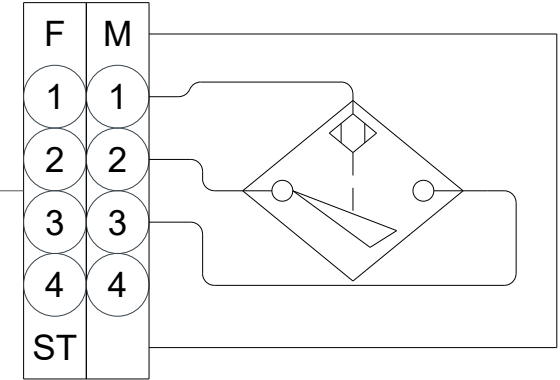
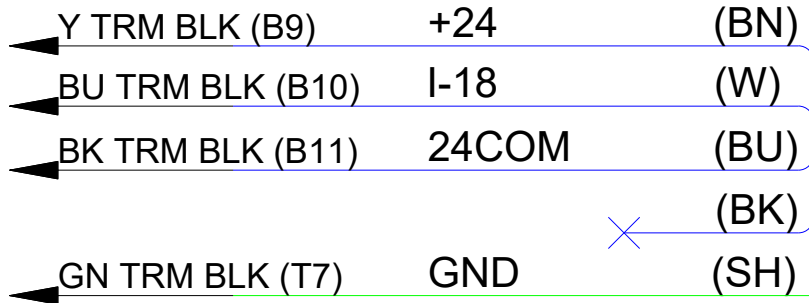
1500 WIRE DIAGRAMS			
NC	FRONT DOOR SENSOR	3.3.21	CH

NIP ROLLER

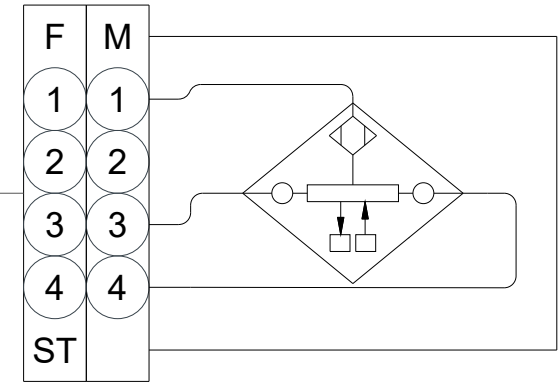
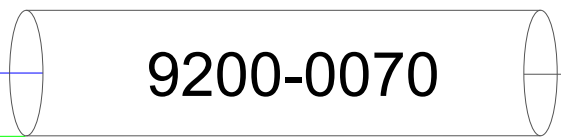
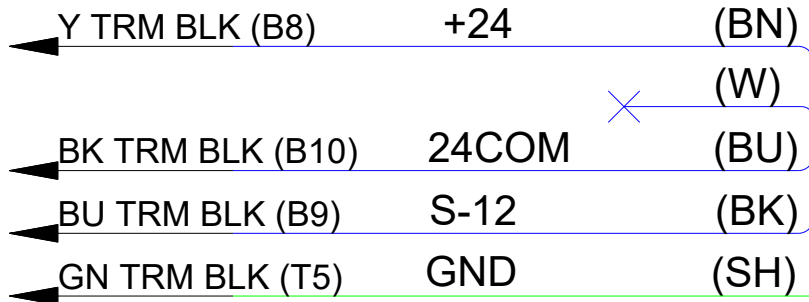


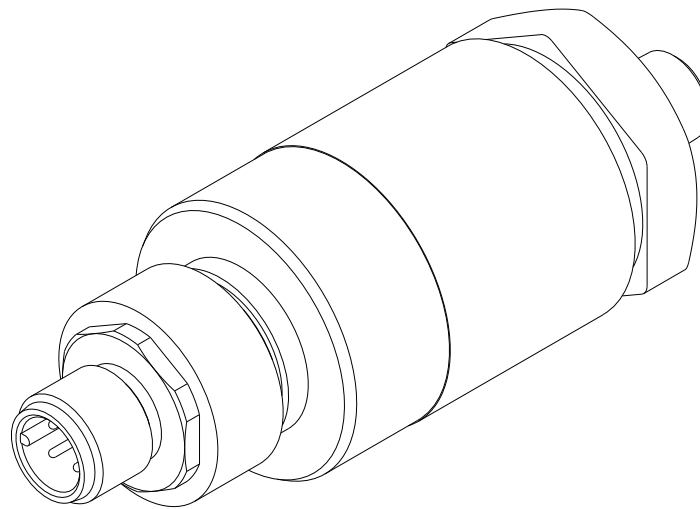
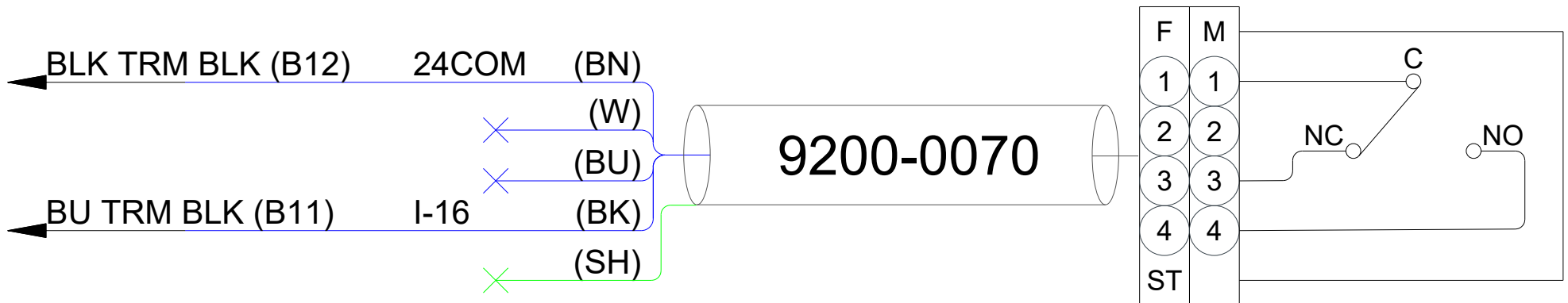


1505-0100 LOW FILM SENSOR

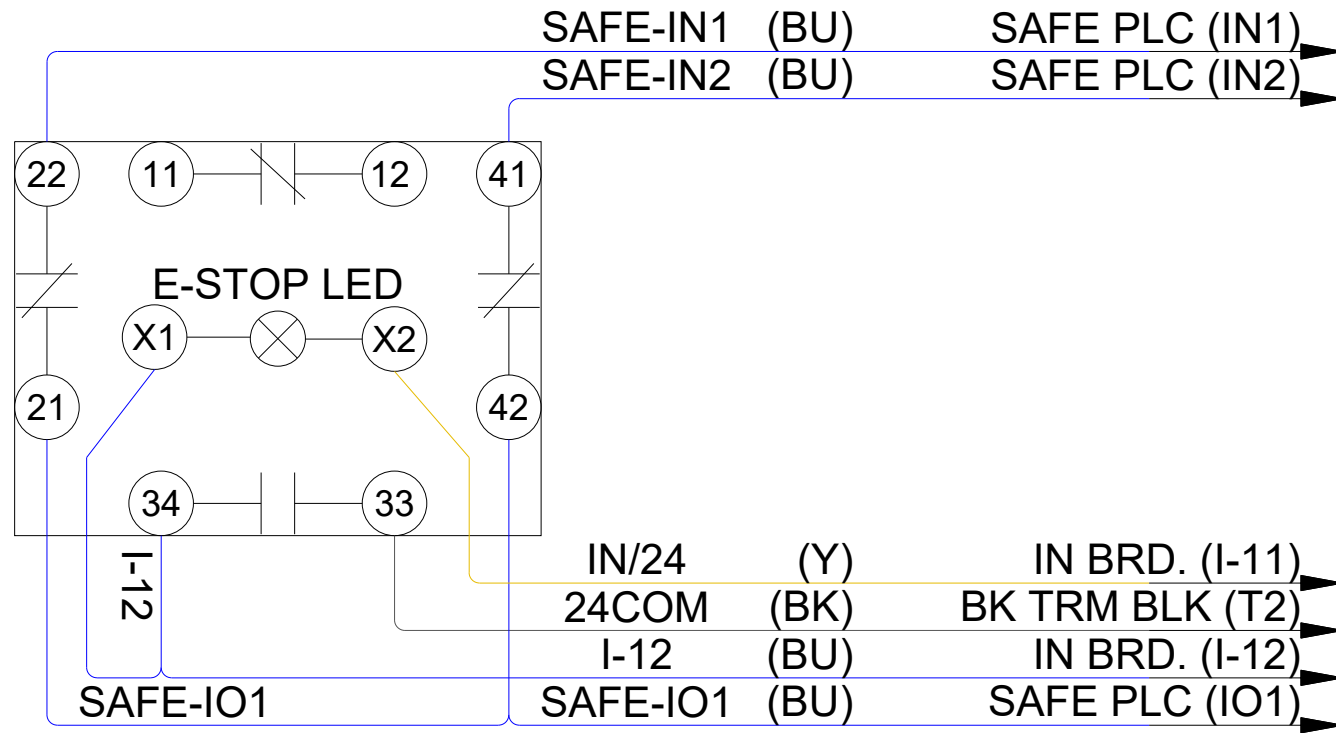
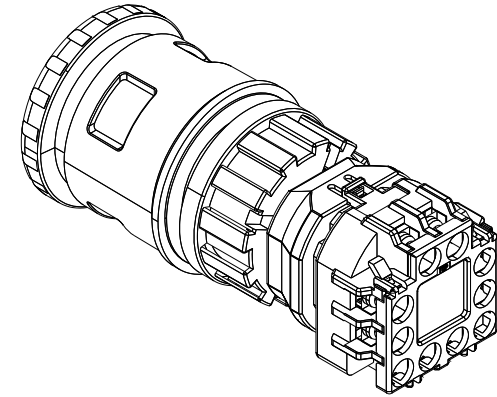


1518-0006SS SENSOR



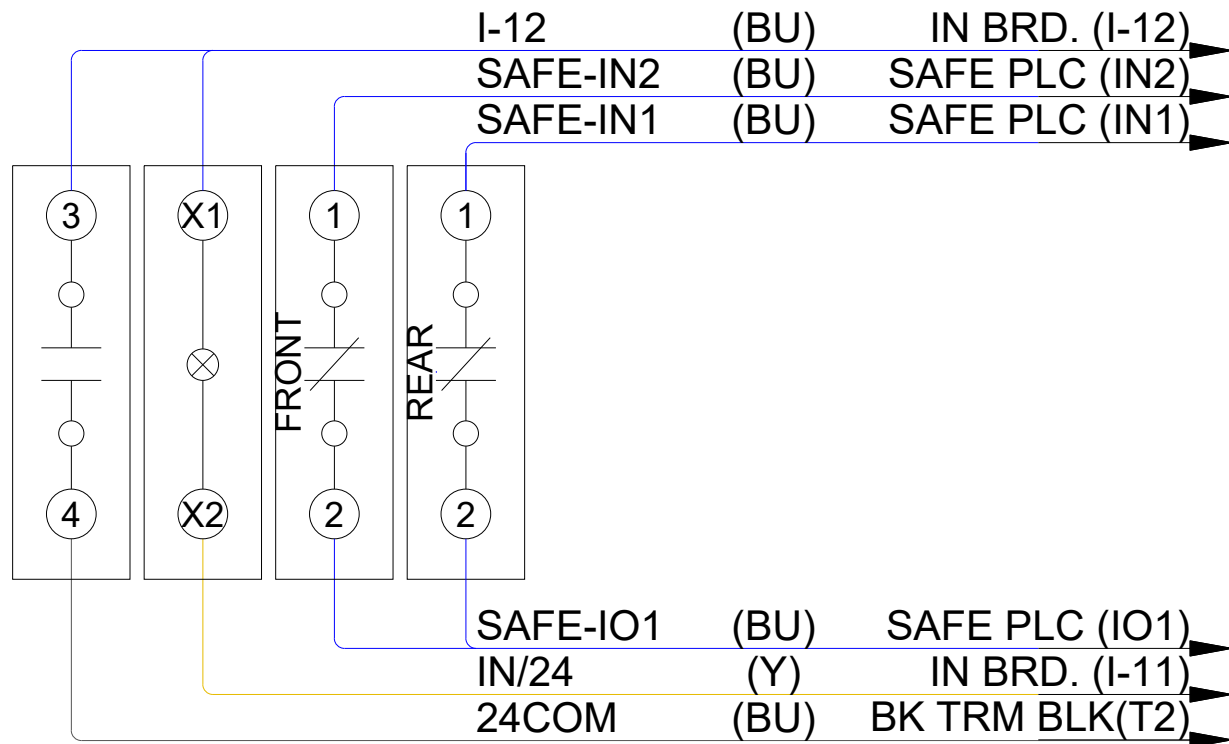
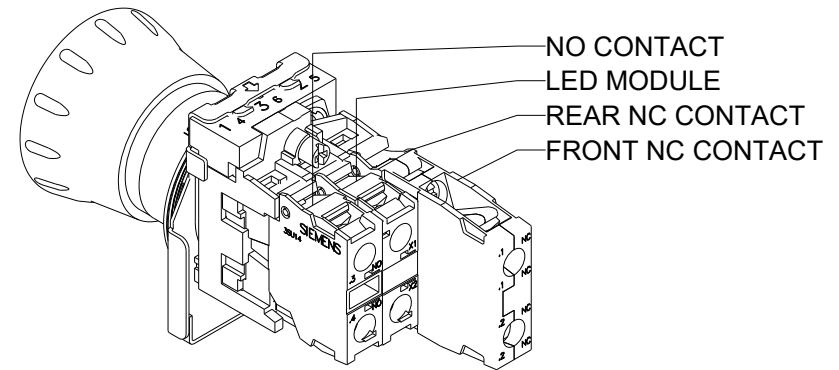


PS182CAN01 REV A (9216-0007) PRESSURE SWITCH



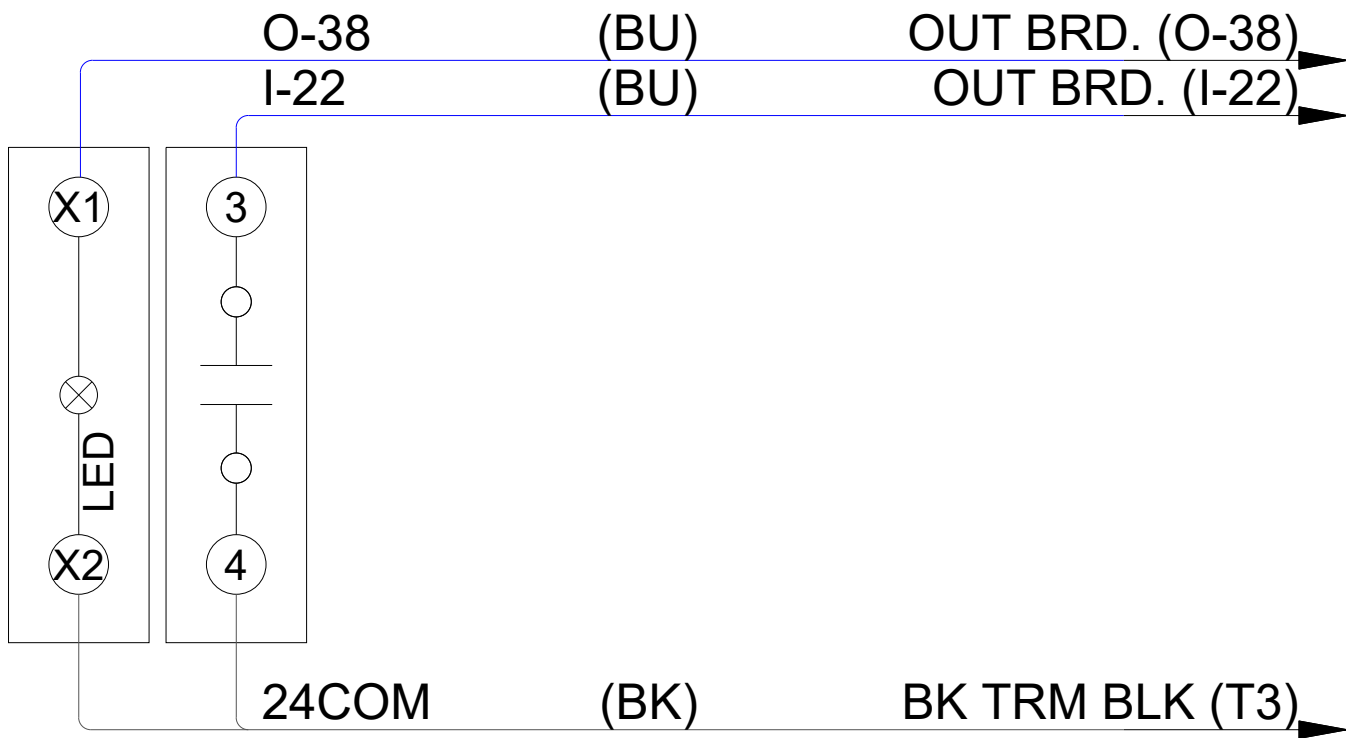
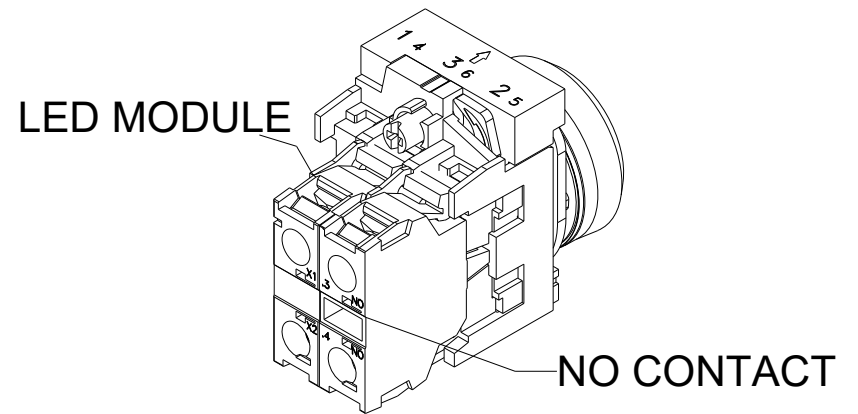
REVISIONS			
NC	INITIAL RELEASE	3.3.21	CH

1500 WIRE DIAGRAMS			
NC	9218-0008UL2 E-STOP BUTTON	3.3.21	CH



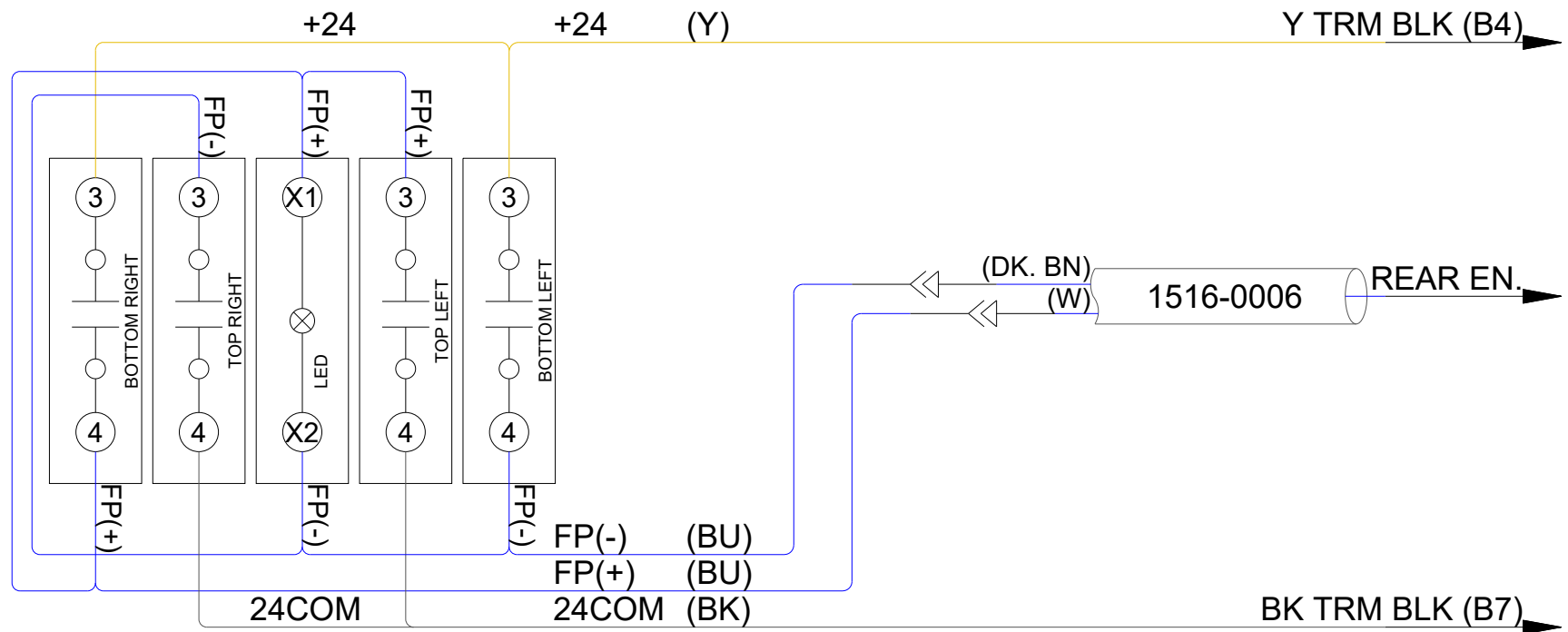
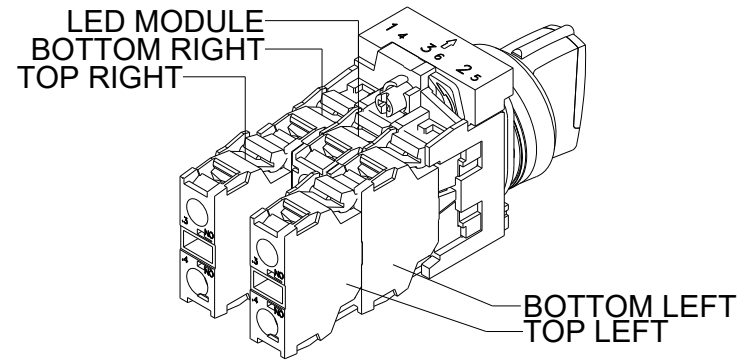
REVISIONS			
NC	INITIAL RELEASE	3.3.21	CH

1500 WIRE DIAGRAMS			
NC	1518-0008 E-STOP BUTTON	3.3.21	CH



REVISIONS			
NC	INITIAL RELEASE	3.3.21	CH

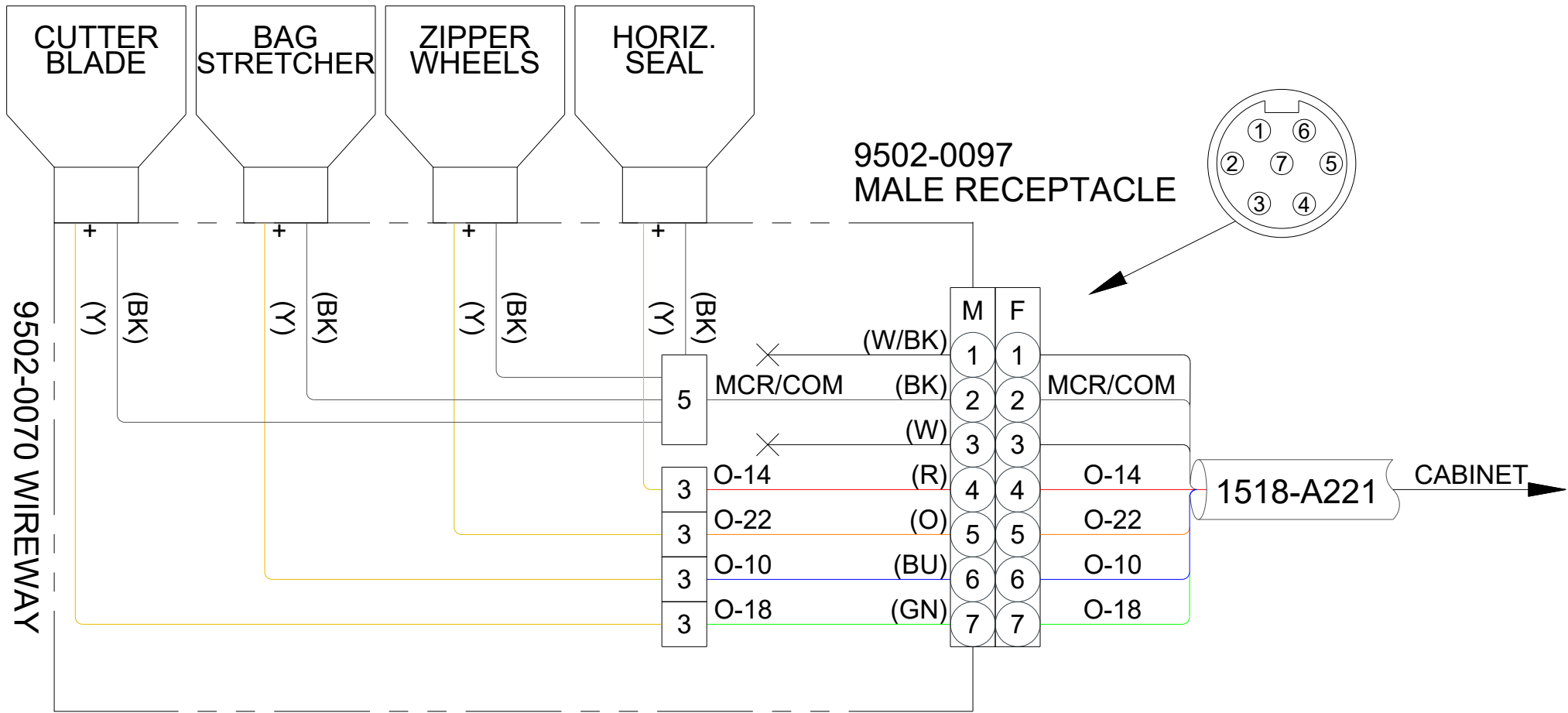
1500 WIRE DIAGRAMS			
NC	RESET/START BUTTON	3.3.21	CH



MOMENTARY-OFF-MOMENTARY
 RIGHT LEFT

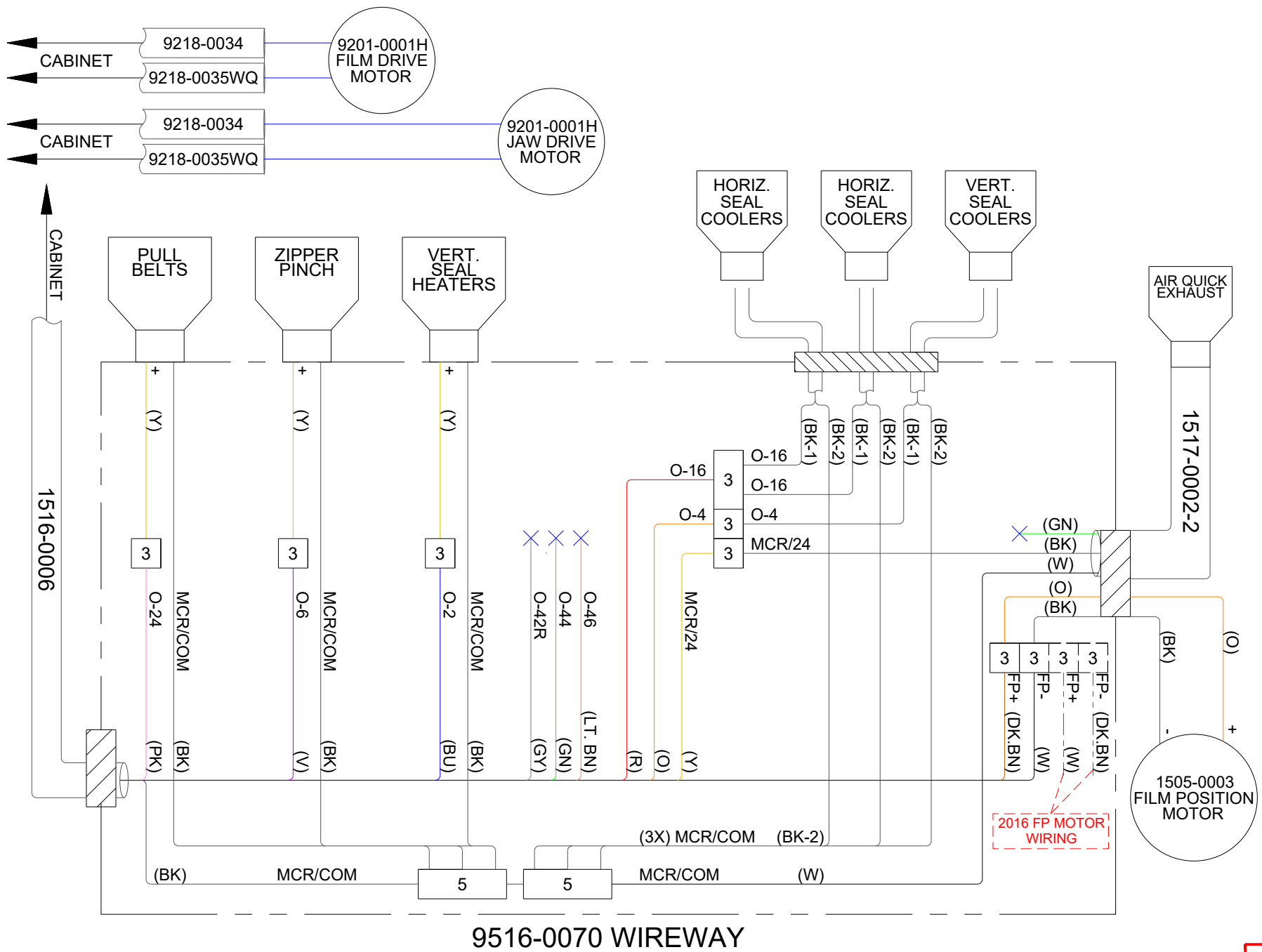
REVISIONS			
NC	INITIAL RELEASE	3.3.21	CH

1500 WIRE DIAGRAMS			
NC	FILM POSITION SWITCH	3.3.21	CH



REVISIONS			
NC	INITIAL RELEASE	3.3.21	CH

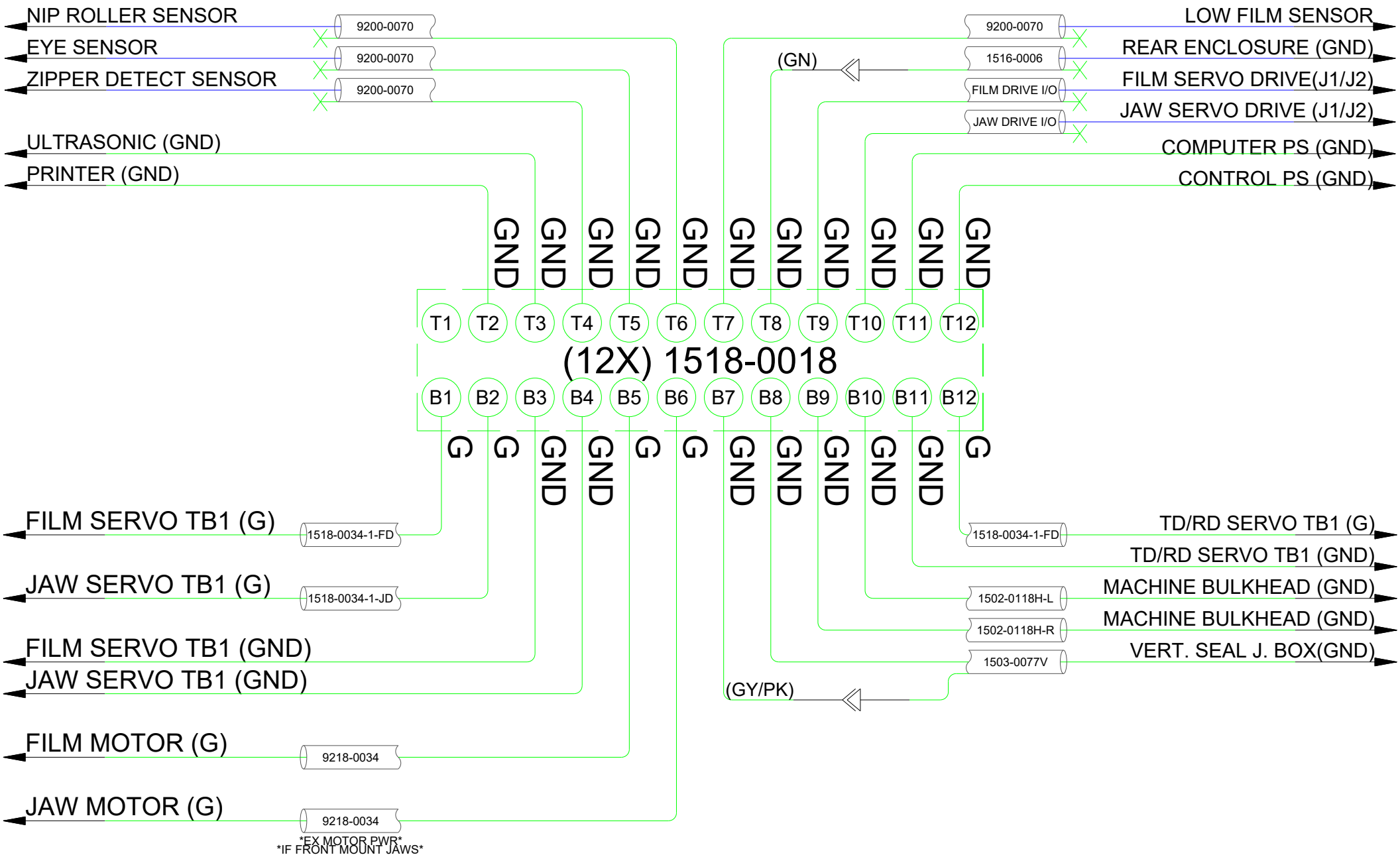
1500 WIRE DIAGRAMS			
NC	LOWER JAW ASSY	3.3.21	CH



9516-0070 WIREWAY

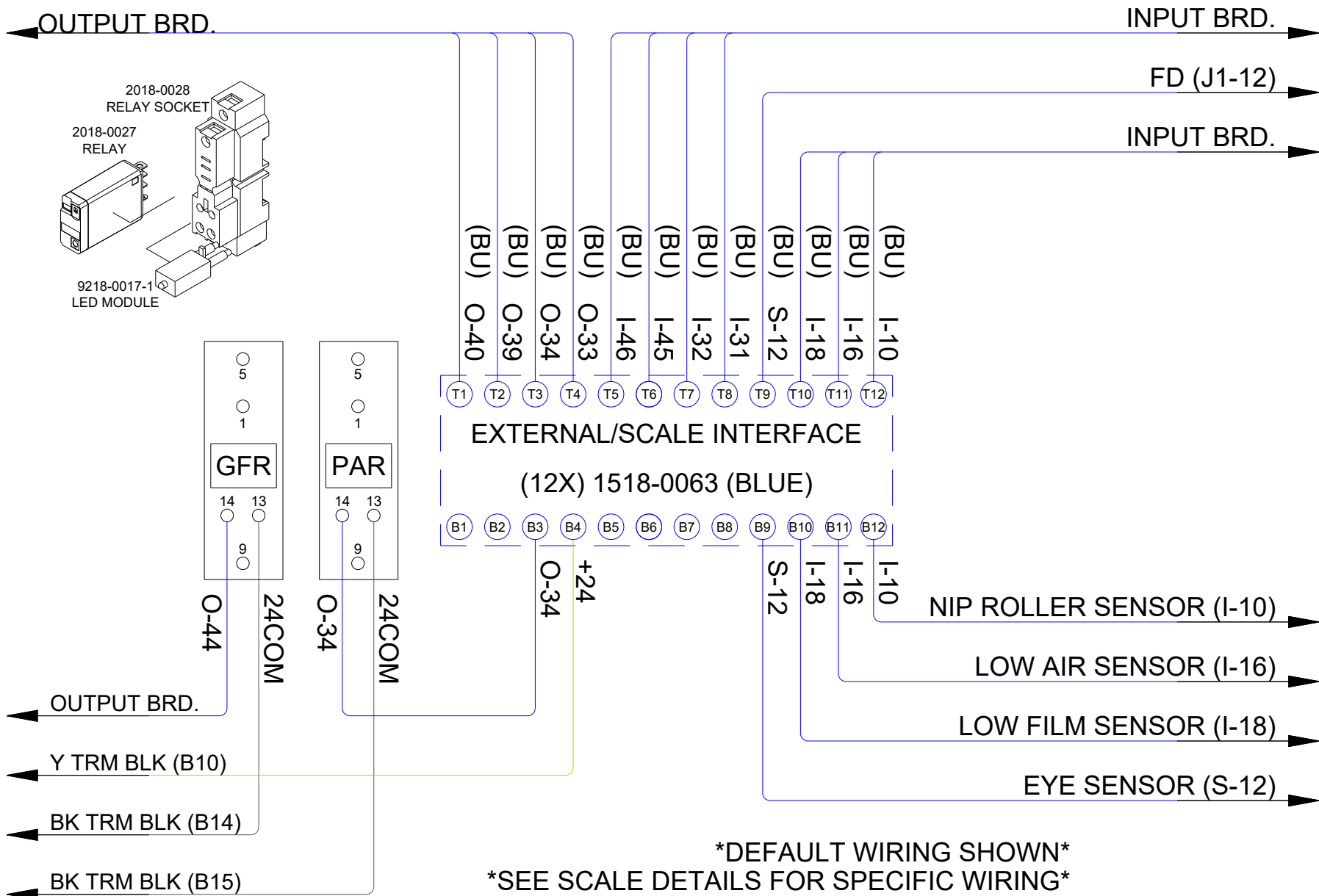
REVISIONS			
NC	INITIAL RELEASE	3.3.21	CH

1500 WIRE DIAGRAMS			
NC	REAR ENCLOSURE	3.3.21	CH



REVISIONS			
NC	INITIAL RELEASE	3.3.21	CH

1500 WIRE DIAGRAMS			
NC	TERMINAL BLOCKS (CHASSIS GND)	3.3.21	CH

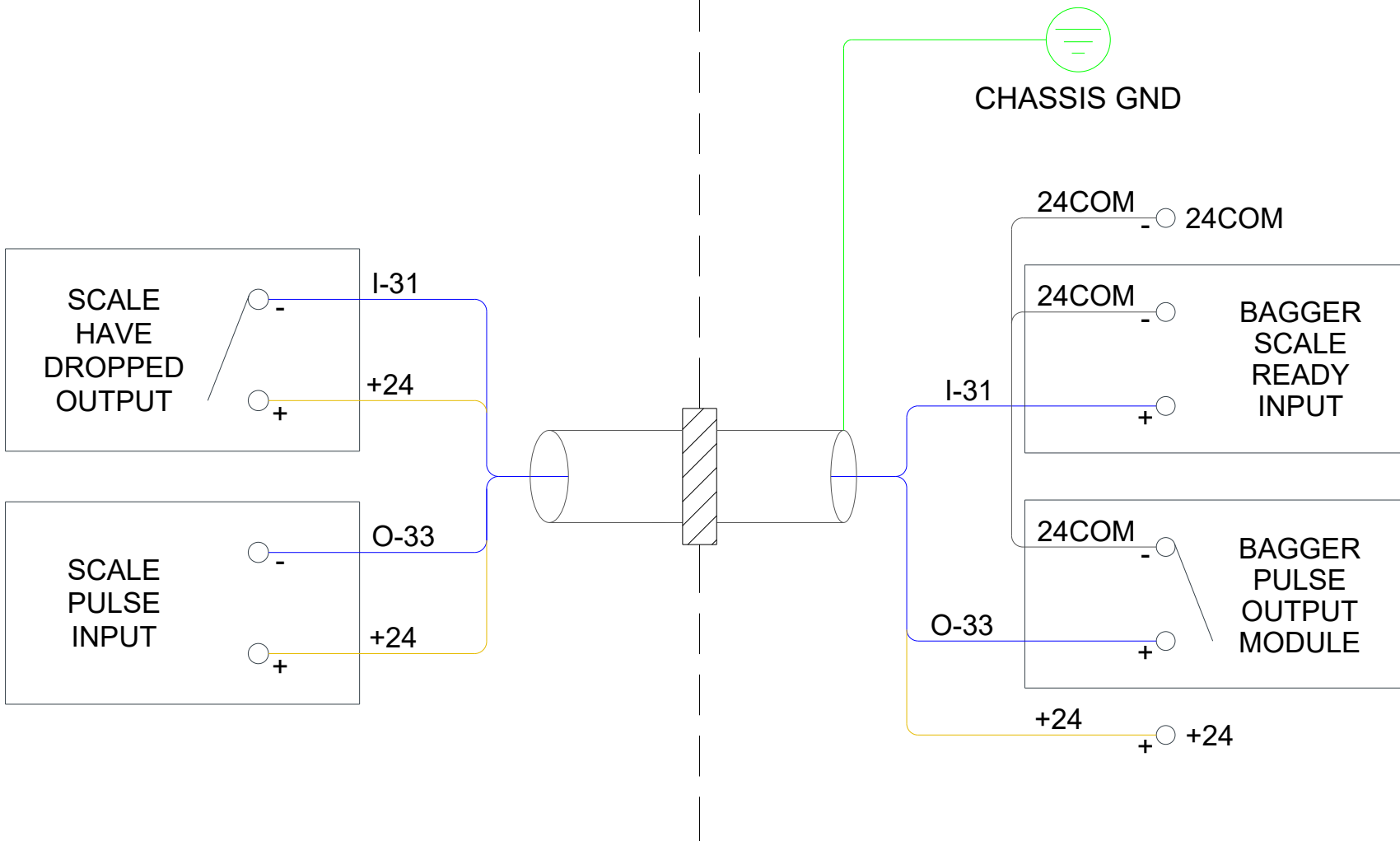


REVISIONS			
NC	INITIAL RELEASE	3.3.21	CH

1500 WIRE DIAGRAMS			
NC	EXTERNAL/SCALE INTERFACE TRM BLKS	3.3.21	CH

SCALE

BAGGER



24COM SUPPLIED BY BAGGER
CONNECT DRAIN WIRE TO BAGGER CHASSIS GROUND

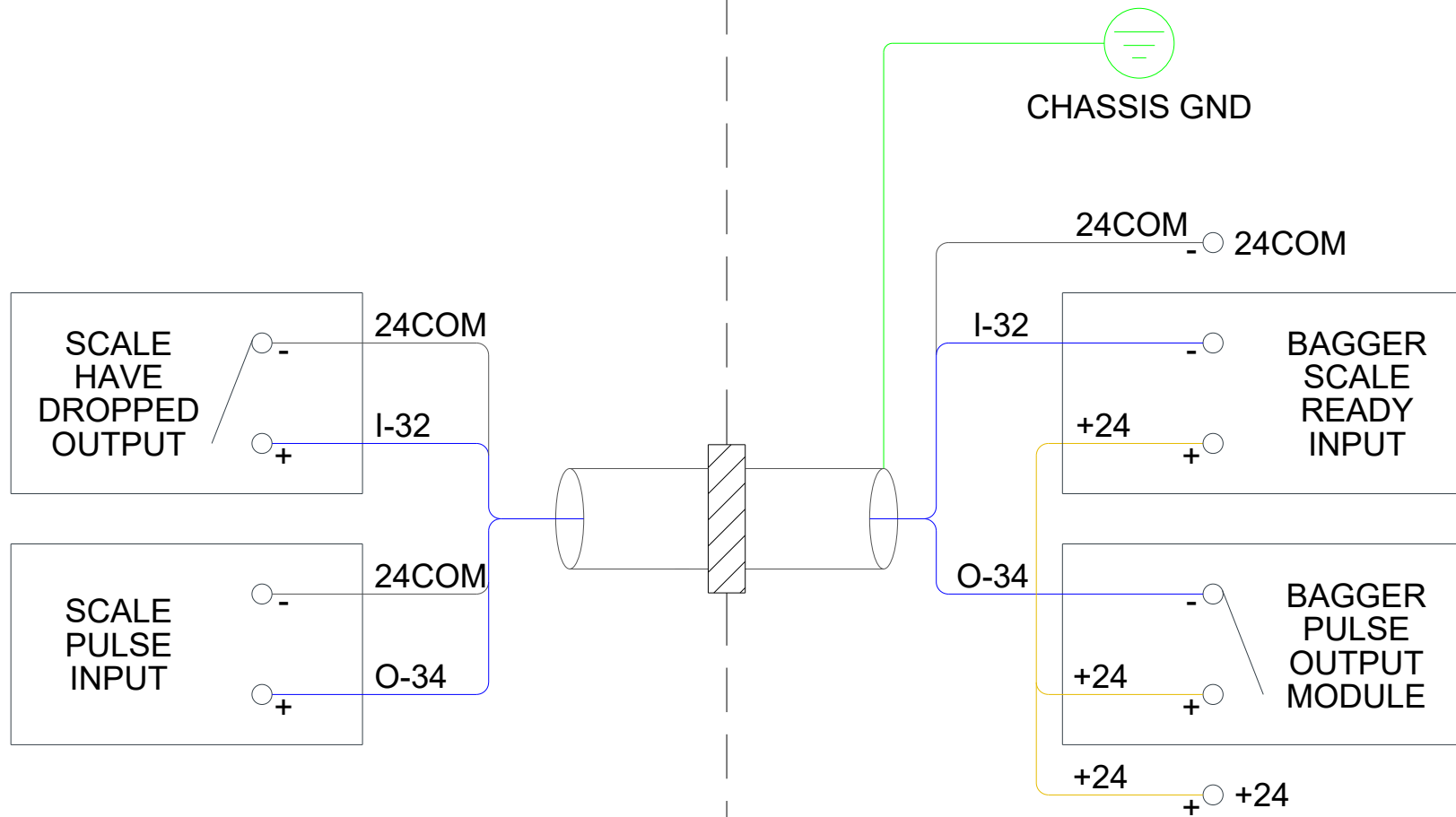
SCALE DETAIL

REVISIONS			
NC	INITIAL RELEASE	3.3.21	CH

1500 WIRE DIAGRAMS			
NC	SCALE DETAIL (BAGGER 24C)	3.3.21	CH

SCALE

BAGGER



+24 SUPPLIED BY BAGGER
CONNECT DRAIN WIRE TO BAGGER CHASSIS GROUND

SCALE DETAIL

REVISIONS

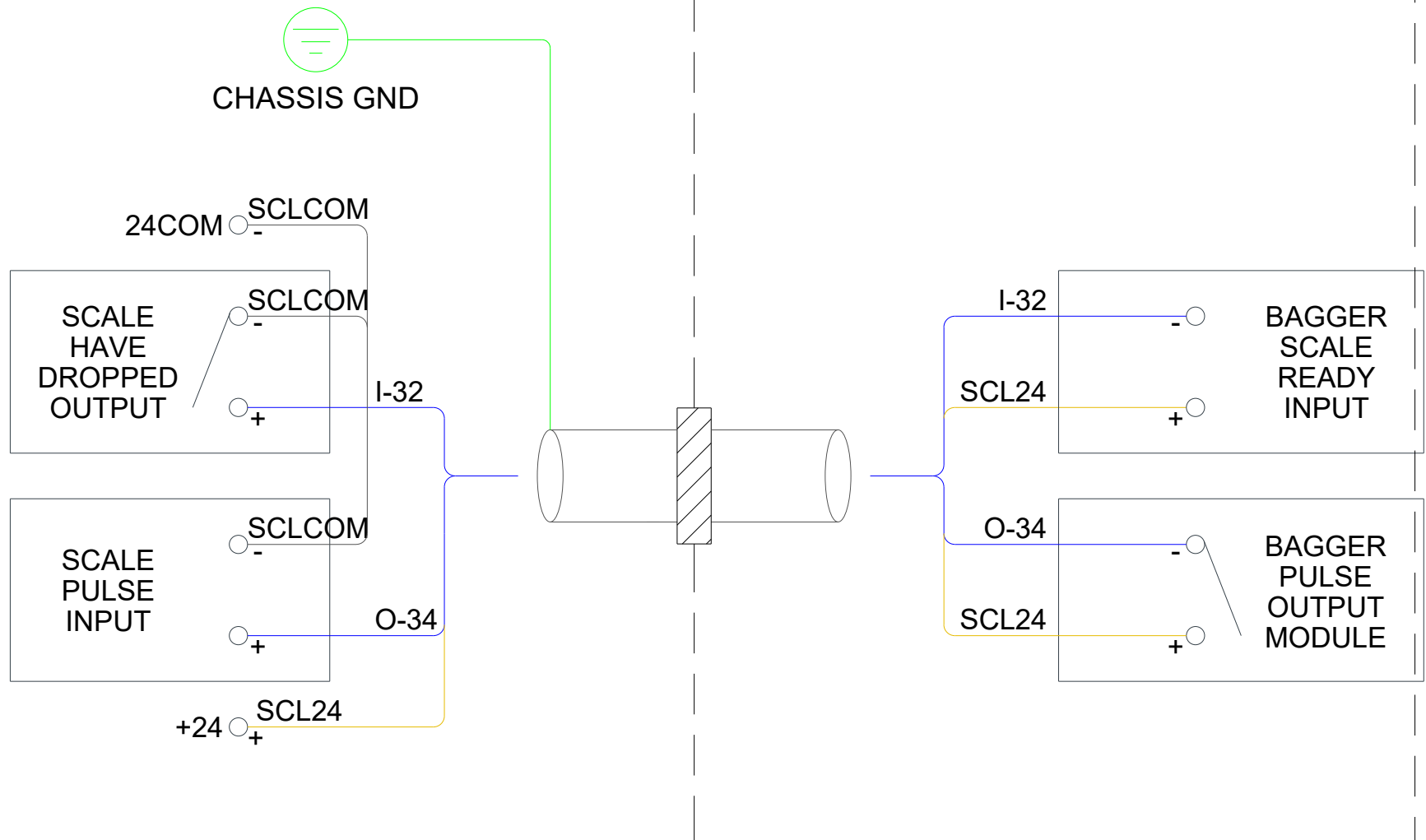
NC	INITIAL RELEASE	3.3.21	CH
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1500 WIRE DIAGRAMS

NC	SCALE DETAIL (BAGGER +24)	3.3.21	CH
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SCALE

BAGGER



24COM SUPPLIED BY SCALE
 CONNECT DRAIN WIRE TO SCALE CHASSIS GROUND

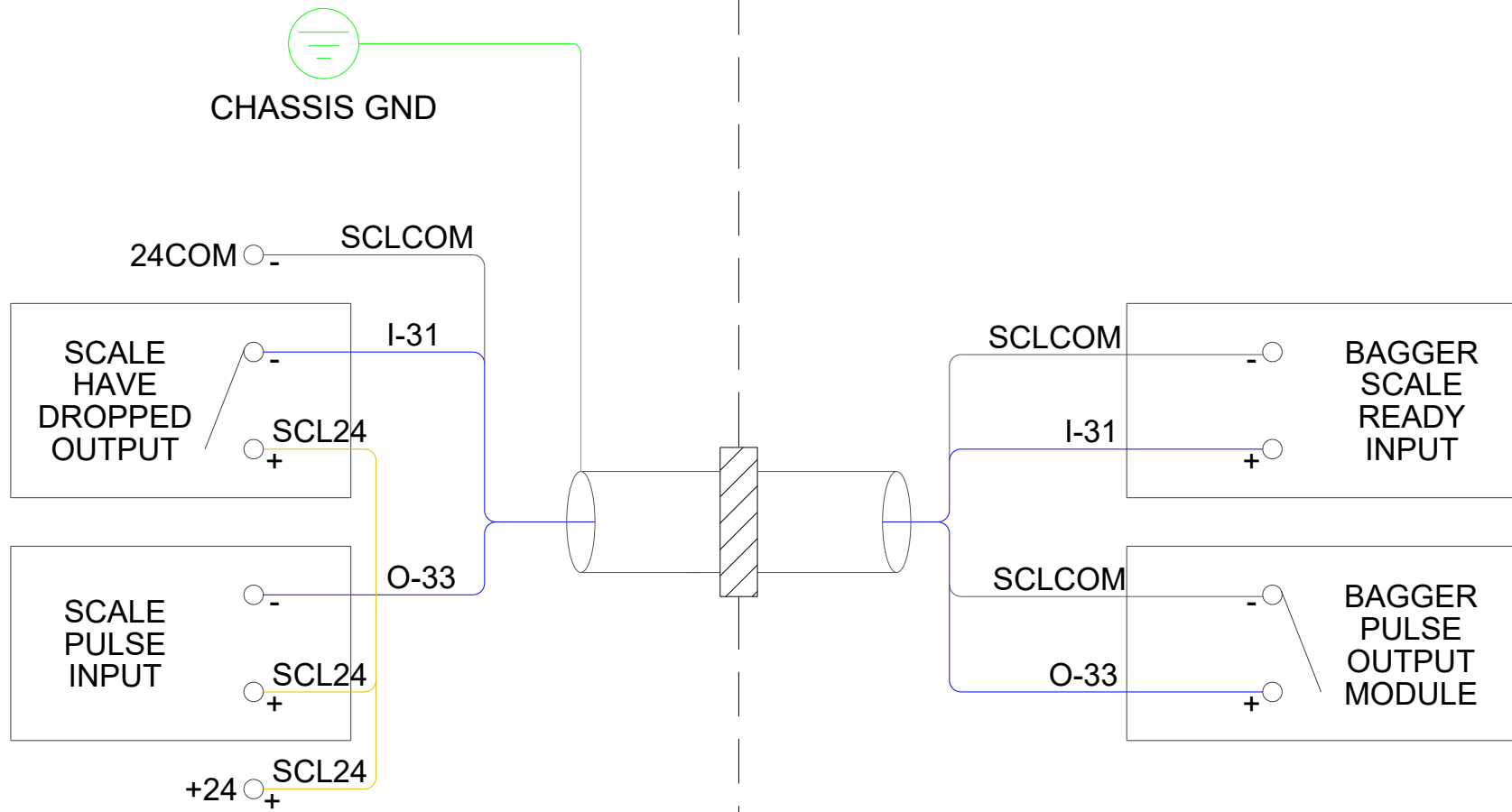
SCALE DETAIL

REVISIONS			
NC	INITIAL RELEASE	3.3.21	CH

1500 WIRE DIAGRAMS			
NC	SCALE DETAIL (SCALE 24C)	3.3.21	CH

SCALE

BAGGER



+24 SUPPLIED BY SCALE
 CONNECT DRAIN WIRE TO SCALE CHASSIS GROUND

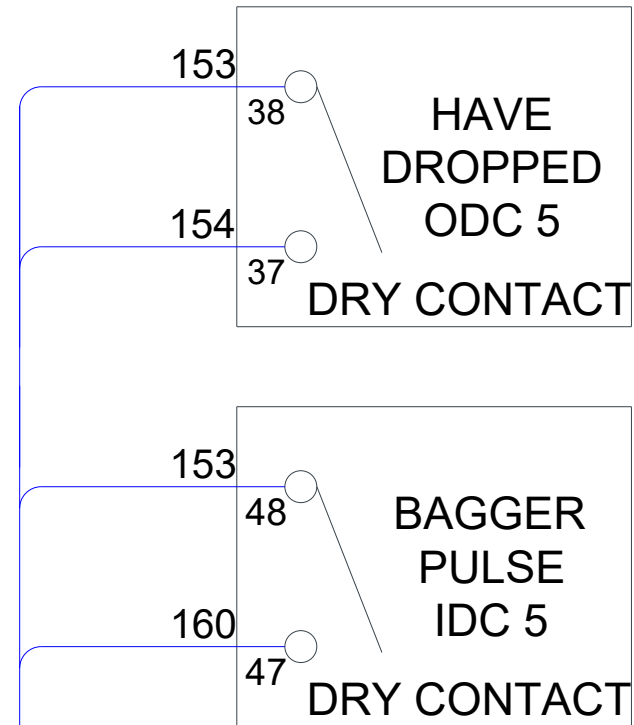
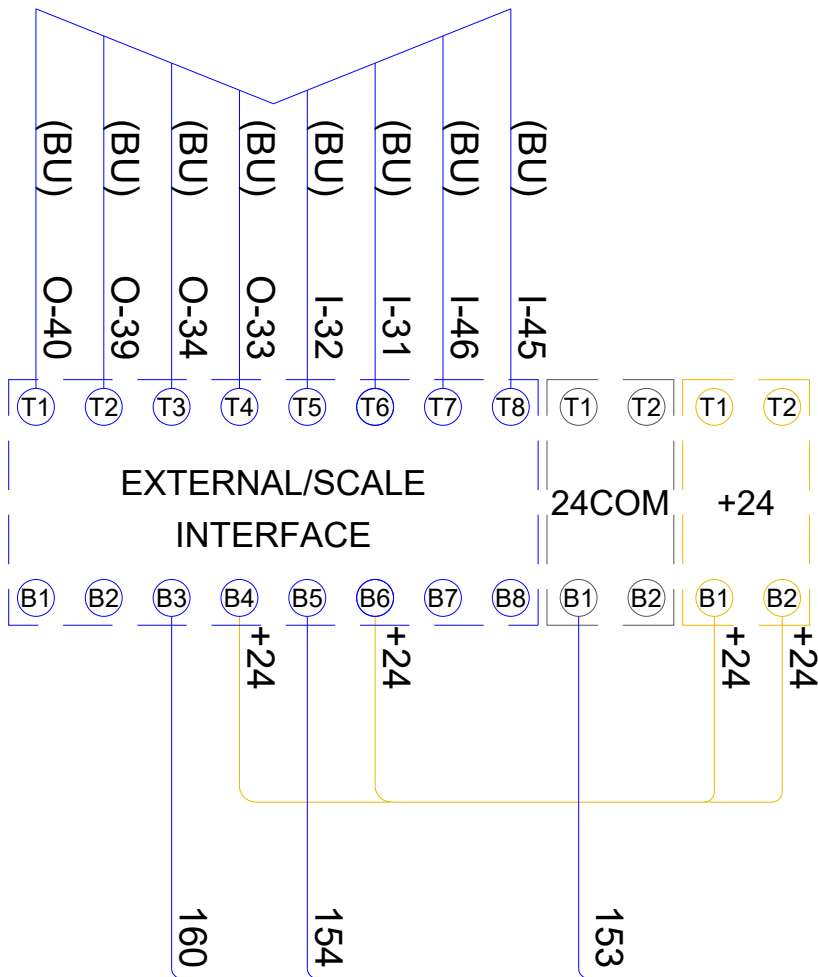
SCALE DETAIL

REVISIONS			
NC	INITIAL RELEASE	3.3.21	CH

1500 WIRE DIAGRAMS			
NC	SCALE DETAIL (SCALE +24)	3.3.21	CH

BAGGER

SCALE

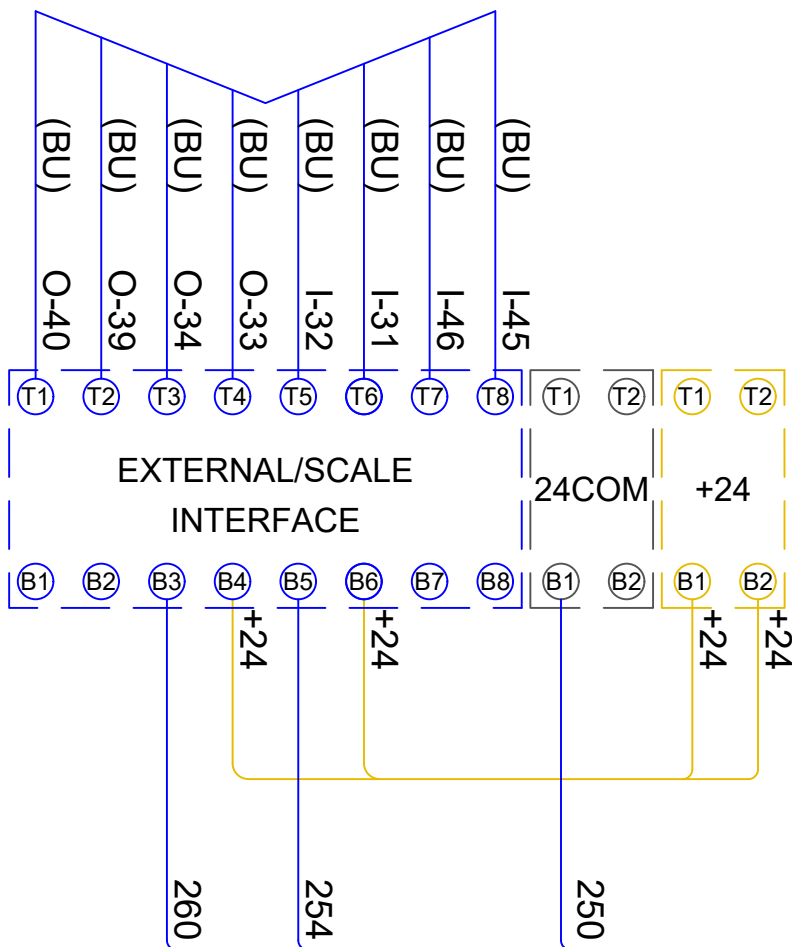


INSIDE 1500 INTERFACE FOR OLD EAGLE SCALE

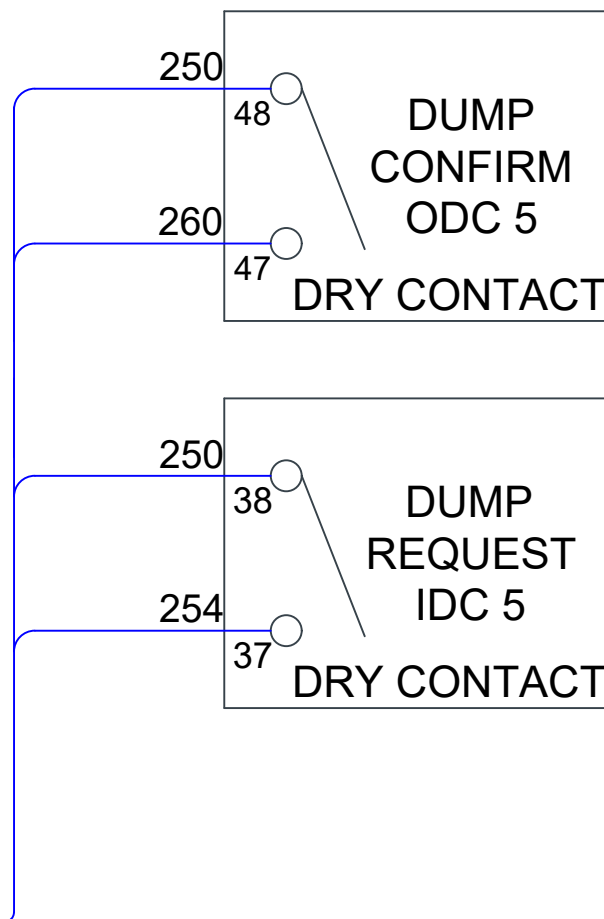
REVISIONS			
NC	INITIAL RELEASE	3.3.21	CH

1500 WIRE DIAGRAMS			
NC	OLD EAGLE SCALE	3.3.21	CH

BAGGER



SCALE



INSIDE 1500 INTERFACE FOR NEW EAGLE SCALE

REVISIONS

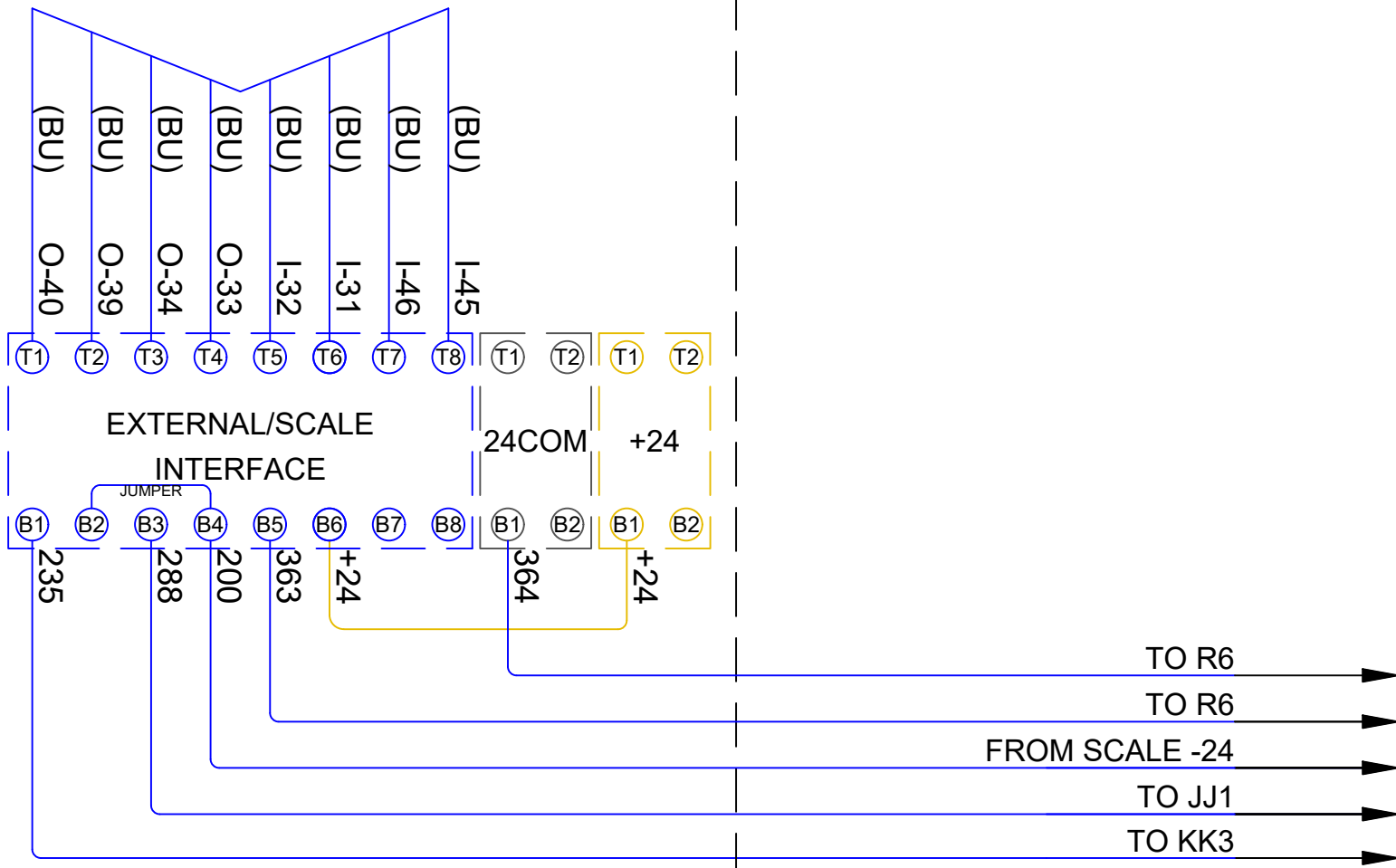
NC	INITIAL RELEASE	3.3.21	CH
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1500 WIRE DIAGRAMS

NC	NEW EAGLE SCALE	3.3.21	CH
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BAGGER

SCALE



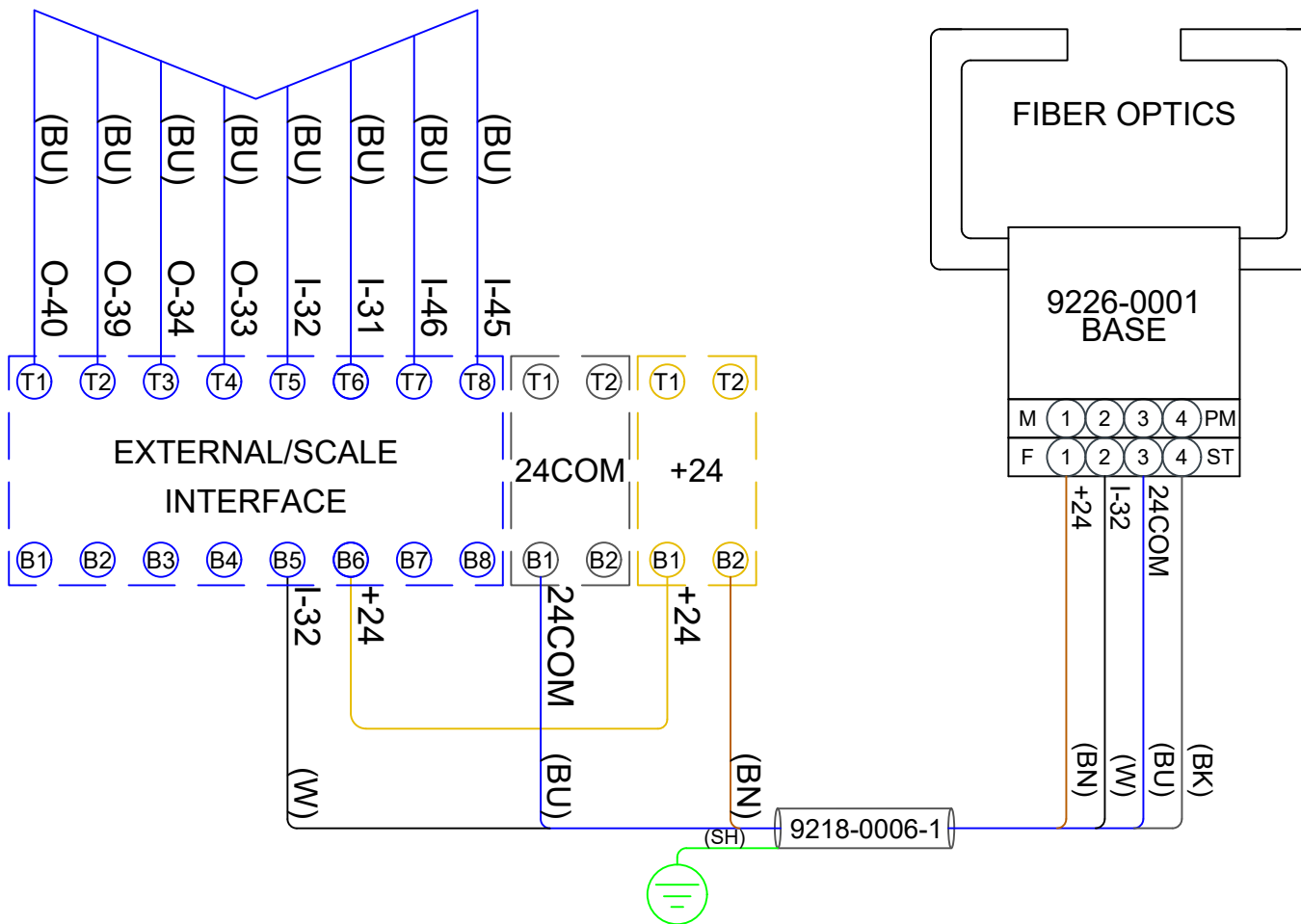
INSIDE 1500 INTERFACE FOR TRIANGLE SCALE

REVISIONS

NC	INITIAL RELEASE	3.3.21	CH
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1500 WIRE DIAGRAMS

NC	TRIANGLE SCALE	3.3.21	CH
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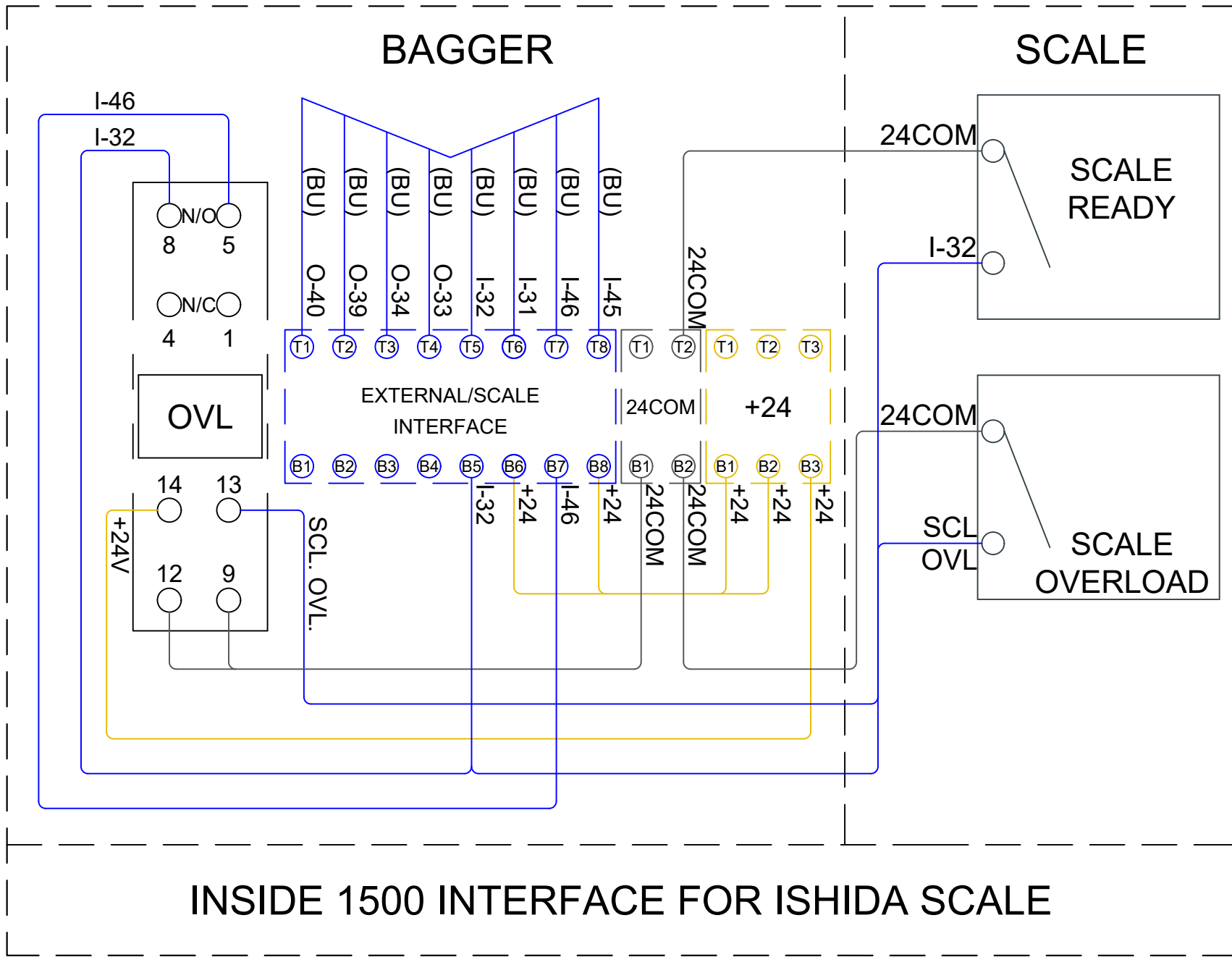
9526 PRODUCT INFEEED EYE ASSEMBLY SLAVE MODE

REVISIONS

NC	INITIAL RELEASE	3.3.21	CH
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1500 WIRE DIAGRAMS

NC	9526 PRODUCT INFEEED EYE ASSY	3.3.21	CH
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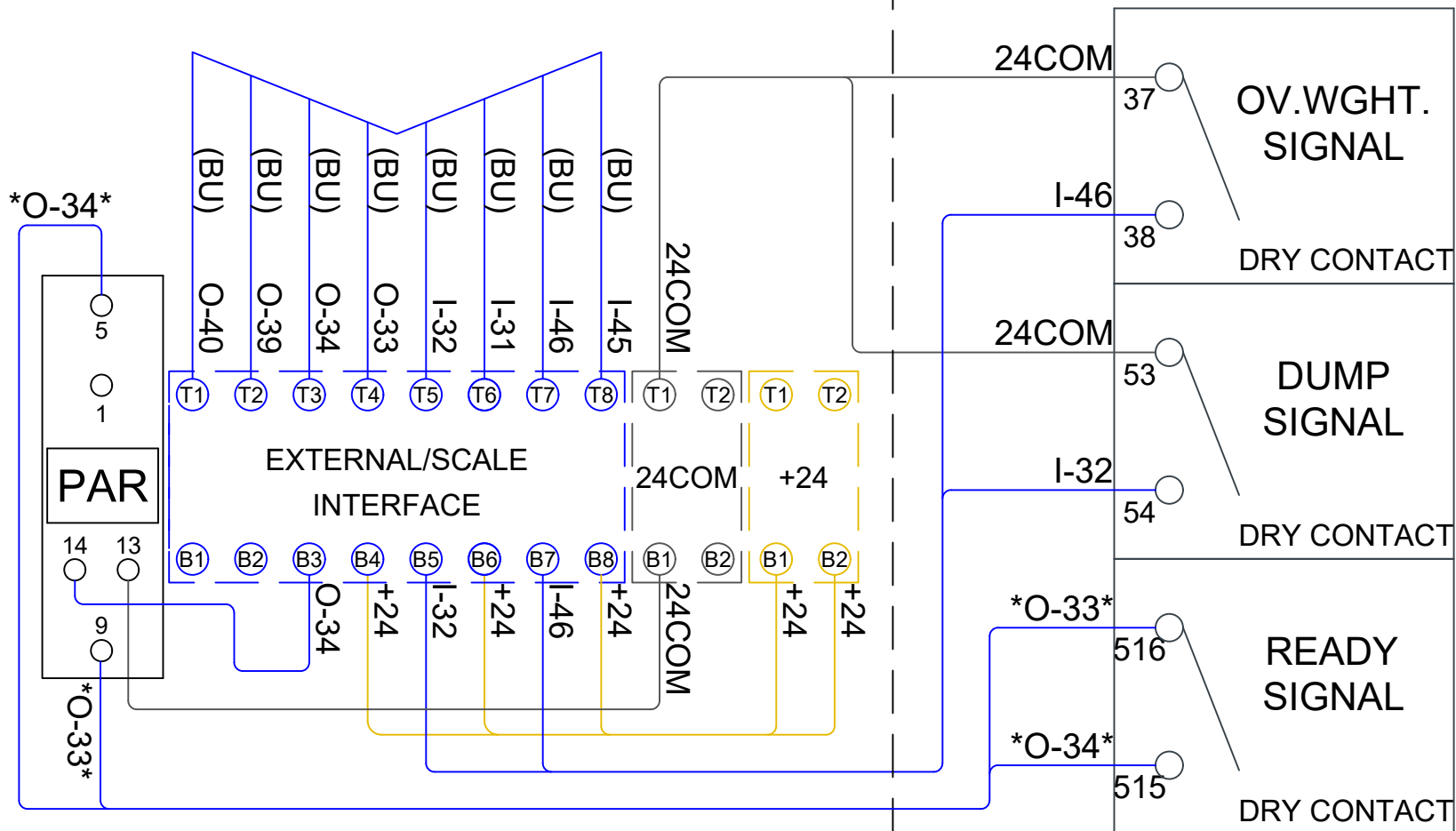


REVISIONS			
NC	INITIAL RELEASE	3.3.21	CH

1500 WIRE DIAGRAMS			
NC	ISHIDA SCALE	3.3.21	CH

BAGGER

SCALE



INSIDE 1500 INTERFACE FOR YAMATA SCALE

REVISIONS

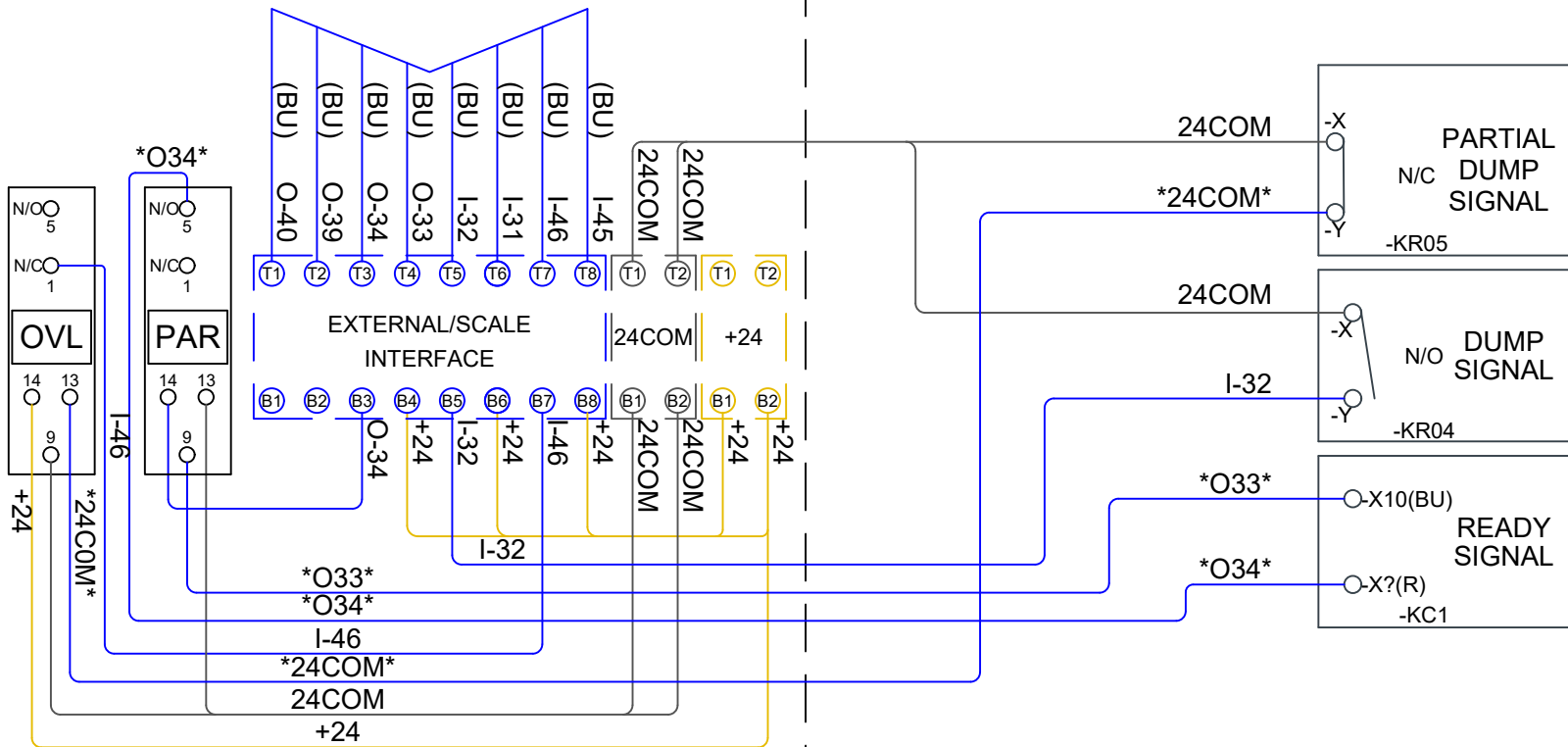
NC	INITIAL RELEASE	3.3.21	CH
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1500 WIRE DIAGRAMS

NC	YAMATA SCALE	3.3.21	CH
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BAGGER

SCALE



INSIDE 1500 INTERFACE FOR MAREL SCALE

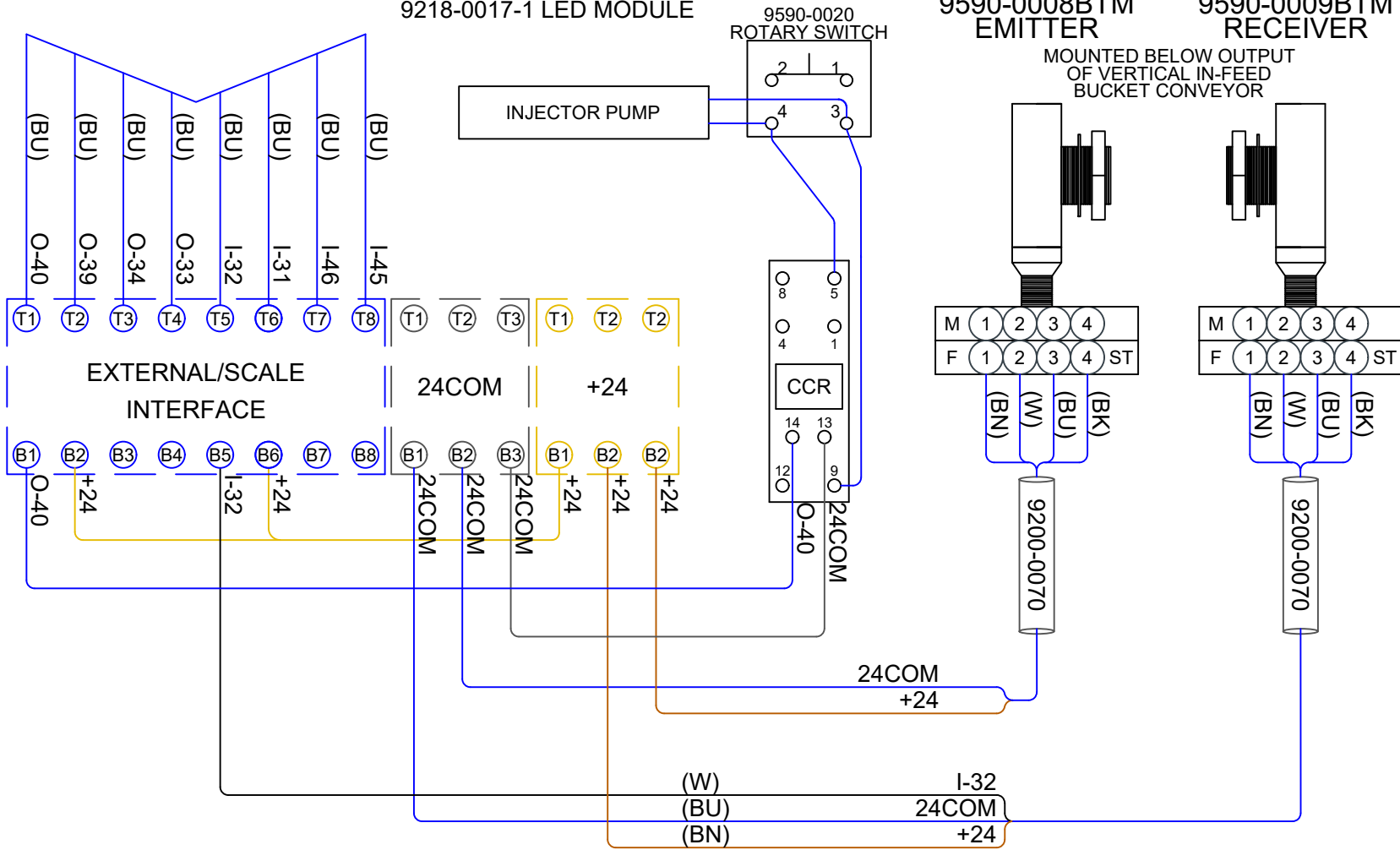
REVISIONS

NC	INITIAL RELEASE	3.3.21	CH
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1500 WIRE DIAGRAMS

NC	MAREL SCALE	3.3.21	CH
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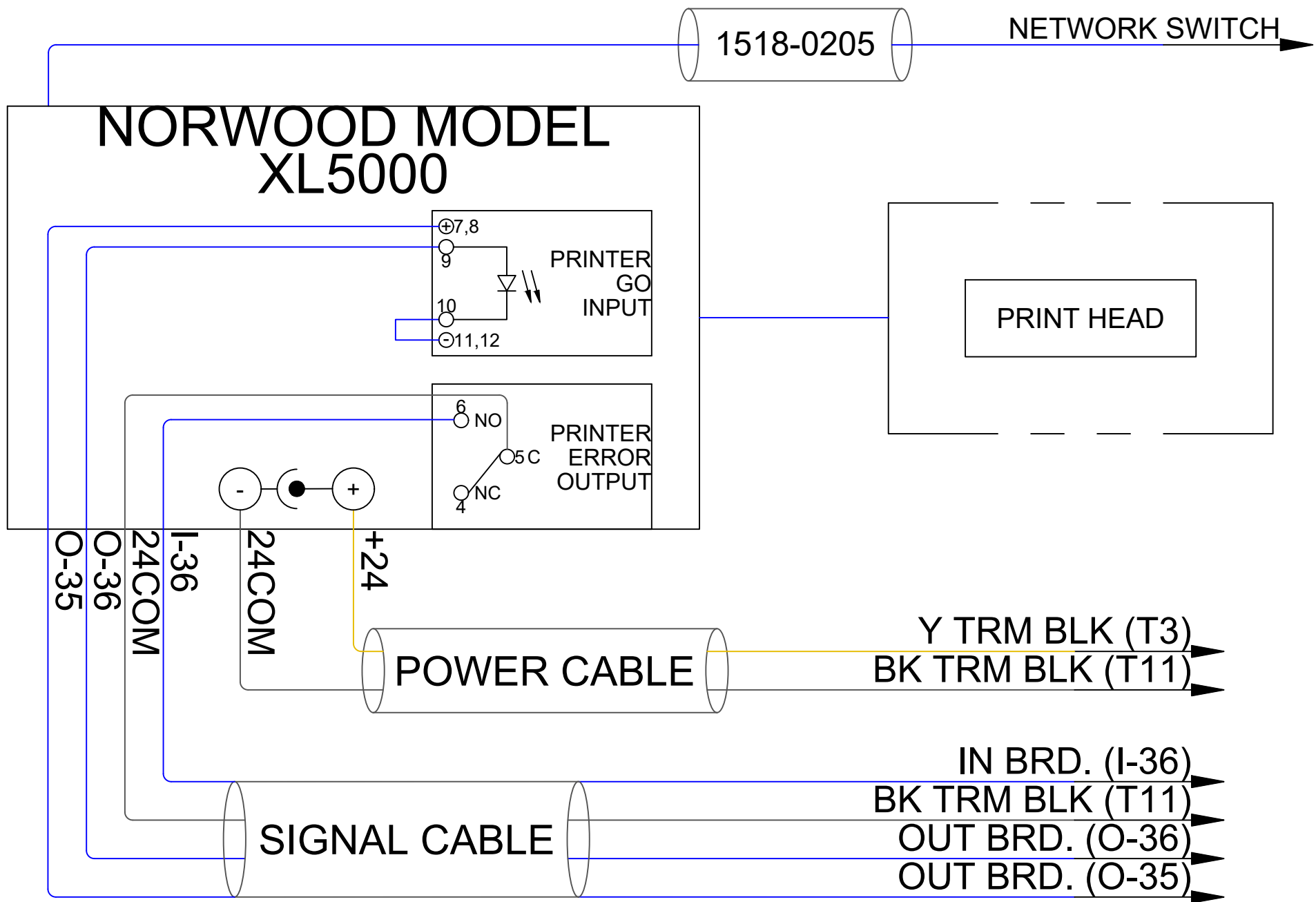
CCR = CONVEYOR CONTROL RELAY
 9218-0017 RELAY
 9218-0028 RELAY SOCKET
 9218-0017-1 LED MODULE



9590BTM CONVEYOR CONTROL BOX INTERFACE

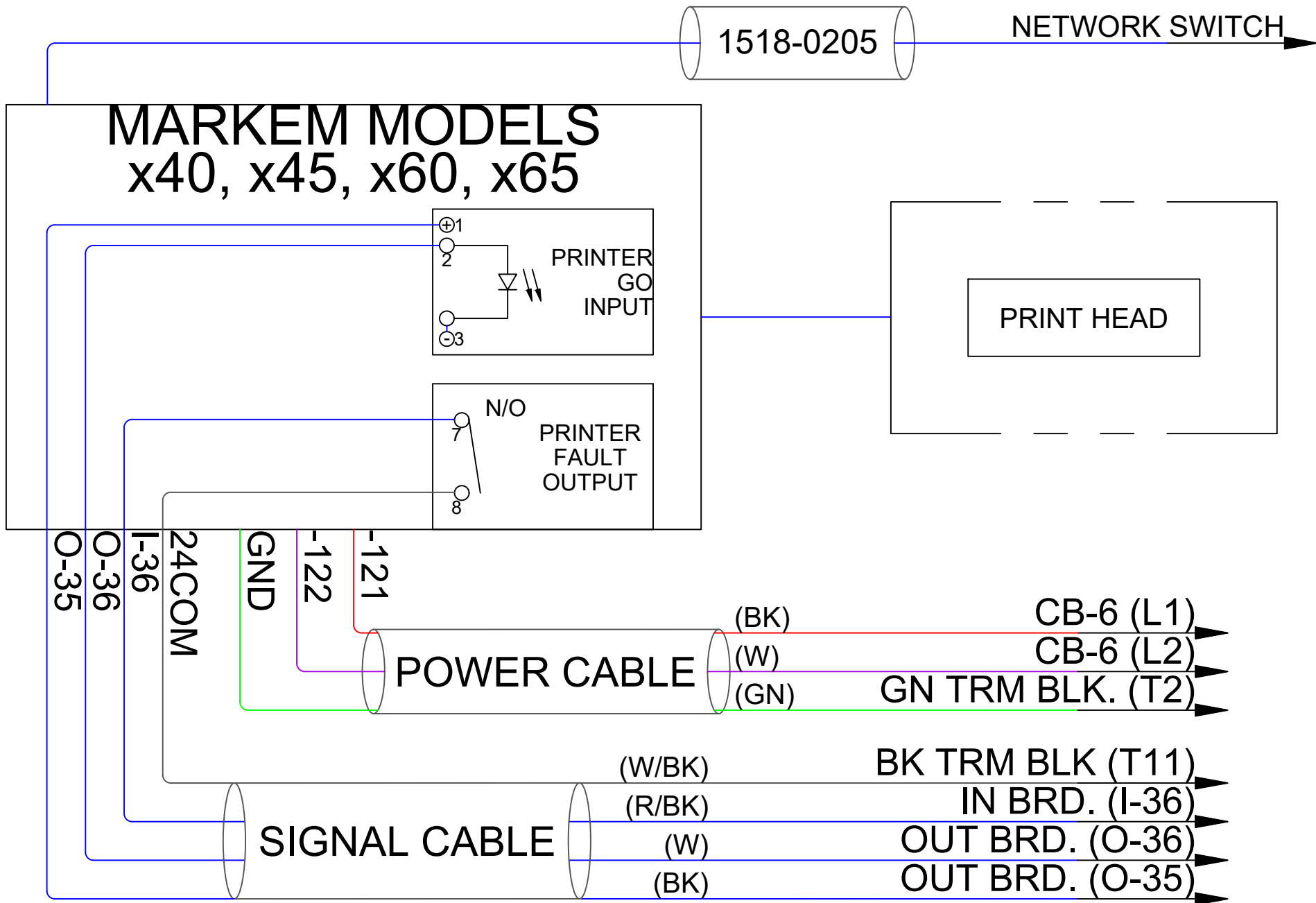
REVISIONS			
NC	INITIAL RELEASE	3.3.21	CH

1500 WIRE DIAGRAMS			
NC	9590BTM CONVEYOR CONTROL	3.3.21	CH



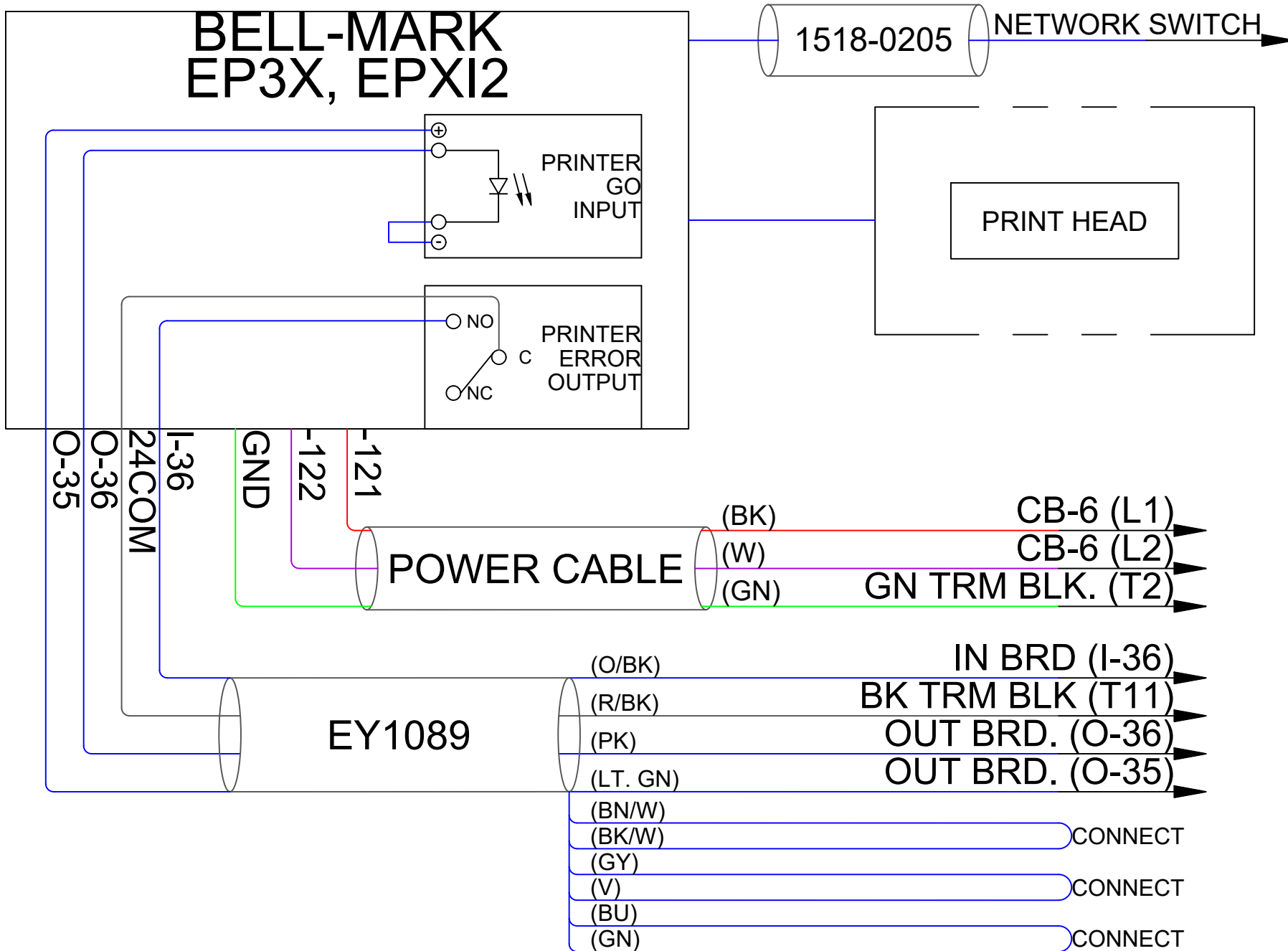
REVISIONS			
NC	INITIAL RELEASE	3.3.21	CH

1500 WIRE DIAGRAMS			
NC	NORWOOD PRINTER	3.3.21	CH



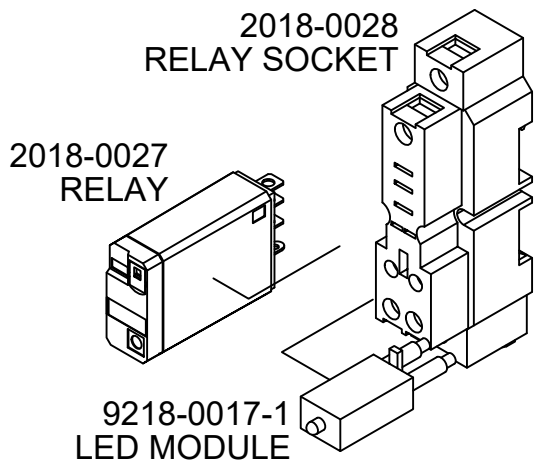
REVISIONS			
NC	INITIAL RELEASE	3.3.21	CH

1500 WIRE DIAGRAMS			
NC	MARKEM PRINTERS	3.3.21	CH

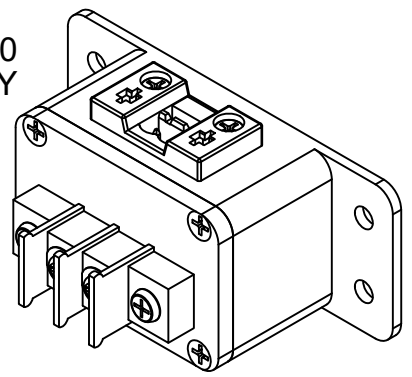


REVISIONS			
NC	INITIAL RELEASE	3.3.21	CH

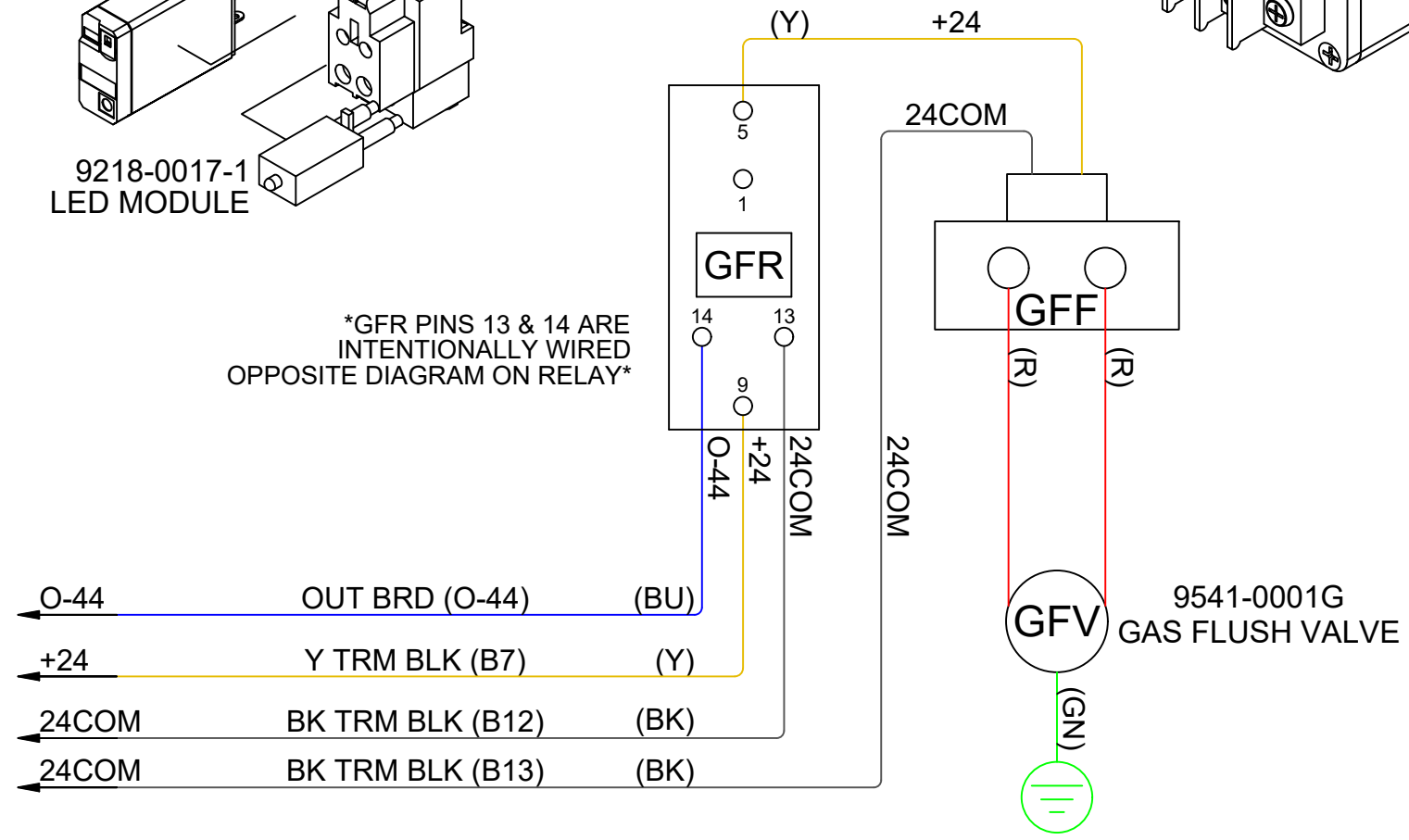
1500 WIRE DIAGRAMS			
NC	BELL-MARK PRINTERS	3.3.21	CH



9541-0100
GAS FLUSH FILTER ASSY



GFR PINS 13 & 14 ARE INTENTIONALLY WIRED OPPOSITE DIAGRAM ON RELAY



REVISIONS			
NC	INITIAL RELEASE	3.3.21	CH

1500 WIRE DIAGRAMS			
NC	GAS FLUSH FILTER ASSY	3.3.21	CH